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(54) Shaped polyester composite material having an activated surface thereof and process for producing the same.

(57) A shaped polyester composite material having an excellent bonding property to rubber, comprises a shaped substrate comprising an aromatic linear polyester matrix and 0.3 to 15%, based on the weight of the matrix, of silicon dioxide fine particles having an average size of 5 to 100 millimicrons and dispersed in at least a surface portion of the substrate, and;

a surface coating layer formed on the fine particle-containing surface portion of the substrate and comprising a surface-activating material consisting of at least one member selected from silane coupling compounds and organic titanium compounds, the surface coating layer having been heat treated at a temperature of 50°C or more but at least 10°C below the melting point of the polyester matrix.

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SHAPED POLYESTER COMPOSITE MATERIAL
HAVING AN ACTIVATED SURFACE THEREOF AND
PROCESS FOR PRODUCING THE SAME

FIELD OF THE INVENTION

The present invention relates to a shaped polyester composite material having an activated surface thereof and a process for producing the same. More particularly, the present invention relates to a shaped polyester composite material, for example, polyester filament or fiber or film composite material, having a surface thereof which exhibits an excellent bonding property to rubber or other polymeric material, and a process for producing the same.

10 BACKGROUND OF THE INVENTION

It is known that shaped polyester articles, for example, polyethylene terephthalate filaments, fibers or films, exhibit an excellent tensile strength, dimensional stability, Young's modulus and resistance to fatigue and creep, and, therefore, useful as a reinforcing material, for example, car tires, conveyer belts, V-belts and hoses.

However, it is also known that the polyester articles inherently have a poor bonding property to rubber or other polymeric materials.

20 It is assumed that the poor bonding property is due to a poor contribution of hydrogen bonds in the ester linkages in the polyester molecules, on the bonding activity thereof. Therefore, when a polyester article is used as the reinforcing material for a rubber article or other
25 polymeric article, the above-mentioned excellent physical properties of the polyester articles cannot be satisfactorily utilized for reinforcing the rubber article or other polymeric article. Accordingly, in order to utilize the polyester articles as the reinforcing material, it is
30 required to significantly improve the bonding property of the polyester articles to rubber or other polymeric materials.

In order to attain this requirement, a number of approaches have been taken in an attempt to enhance the bonding activity of the polyester material. For example, it was attempted to improve the bonding property of the polyester material by treating the surface of the polyester material with a highly activating compound, for example, an epoxy compound or isocyanate compound. This attempt is disclosed in Japanese Patent Application Publication Nos. 42-11482 and 42-9044(1967). However, the results of the attempt was unsatisfactory. That is, the surface-treated product exhibited an unsatisfactory bonding property to rubber and other polymeric materials, especially, at an elevated temperature. Also, it was found that the improvement in the bonding property caused the resultant improved polyester material to have an excessively high stiffness, a poor processability in a shaping or molding process and a poor resistance to fatigue fracture.

SUMMARY OF THE INVENTION

The object of the present invention is to provide a shaped polyester composite material having an activated surface thereof which exhibits an excellent bonding property to rubber or other polymeric materials, and a process for producing the same.

The above-mentioned object can be attained by the shaped polyester composite material of the present invention and the process of the present invention for producing the same.

The shaped polyester composite material of the present invention comprises:

a shaped substrate comprising a polymeric matrix consisting essentially of an aromatic linear polyester and fine solid particles each comprising mainly silicon dioxide and having an average size of 5 to 100 millimicrons, the silicon dioxide fine solid particles being dispersed at least in a portion of the polyester matrix located in a surface portion of the shaped substrate and the amount of the fine particles being in the range of from 0.3 to 15%

based on the weight of the polyester matrix in which the fine particles are dispersed, and;

a surface coating layer formed on the silicon dioxide fine particle-containing surface portion of said shaped substrate and comprising a surface activating material consisting of at least one member selected from the group consisting of silane coupling compounds and organic titanium compounds, the surface coating layer having been heat-treated together with said shaped substrate at a temperature of 50°C or more but at least 10°C below the melting point of the polyester matrix.

The process of the present invention comprises the steps of:

preparing a shaped substrate which comprises a matrix-forming material consisting essentially of an aromatic linear polyester and fine solid particles each comprising mainly silicon dioxide and having an average size of 5 to 100 millimicrons, the silicon dioxide fine solid particles being dispersed at least in a portion of the polyester matrix located in a surface portion of the shaped substrate and the amount of the fine particles being in the range of 0.3 to 15% based on the weight of the polyester matrix in which the fine particles are dispersed;

coating the silicon dioxide fine particle-containing surface portion of the shaped substrate with a surface coating liquid containing a surface activating material consisting of at least one member selected from the group consisting of silane coupling compounds and organic titanium compounds, drying the resultant layer of the surface coating liquid formed on the shaped substrate, and;

heat-treating the resultant precursory composite material at a temperature of 50°C or more but at least 10°C below the melting point of the polyester matrix.

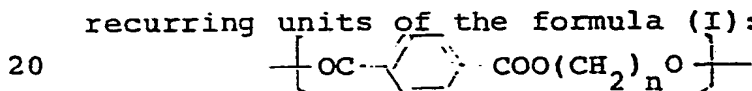
DETAILED DESCRIPTION OF THE INVENTION

In the present invention, the shaped polyester

composite material comprises a shaped substrate and a surface coating layer formed on a surface of the shaped substrate.

The shaped substrate comprises a polymeric matrix
5 consisting essentially of an aromatic linear polyester and fine solid particles comprising mainly silicon dioxide.

The aromatic linear polyester usable for the present invention preferably may be selected from polymerization products of a dicarboxylic acid component consisting of at
10 least one aromatic dicarboxylic acid, for example, terephthalic acid; isophthalic acid, naphthalene dicarboxylic acid or diphenyl dicarboxylic acid or the corresponding functional derivatives of the above-mentioned dicarboxylic acids with a glycol component consisting of at
15 least one glycol compound, for example, ethylene glycol, trimethylene glycol, tetramethylene glycol or hexamethylene glycols. Especially, it is preferable that the aromatic linear polyester has at least 85% by molar amount of recurring units of the formula (I):



wherein n represents an integer of 2 to 6.

More especially, the aromatic linear polyester usable for the present invention is preferably selected from polymerization products of terephthalic acid or naphthalene
25 dicarboxylic acid with ethylene glycol or tetramethylene glycol.

In the polyester, the dicarboxylic acid component may contain, in addition to the above-mentioned aromatic dicarboxylic acid, at least one additional dicarboxylic
30 acid selected from, for example, diphenoxyethane dicarboxylic acid, β -oxyethoxy benzoic acid, p-hydroxybenzoic acid, sebacic acid, adipic acid, oxalic acid, or 1,4-cyclohexane dicarboxylic acid. Also, the glycol component may contain, in addition to the above-mentioned glycol compound, at
35 least one additional diol compound, for example, cyclohexane-1,4-dimethyl alcohol, neopentyl glycol, bisphenol A or bisphenol S.

The fine solid particles comprises silicon dioxide, SiO_2 , preferably in a molar amount of 80% or more. The silicon dioxide may be in any forms of crystals, for example, quartz, cristobalite, tridymite, lechatelierite or opal, or in the amorphous form. In view of reaction activity, especially, to the surface-activating material, it is preferable that the silicon dioxide is amorphous. The amorphous silicon dioxide can be prepared by burning silicon tetrachloride in the presence of molecular oxygen.

10 The resultant amorphous silicon dioxide contains a number of silanol radicals (Si-OH). The silicon dioxide fine particles have an average size of from 5 to 100 millimicrons, preferably, 7 to 50 millimicrons.

In view of the industrial production, it is difficult to produce the fine particles of silicon dioxide having an average size of less than 5 millimicrons. Also, if the average size is more than 100 millimicrons, the resultant mixture of the polyester matrix with the silicon dioxide fine particles exhibits a poor shaping property and processing property. That is, when the mixture is subjected to a melt-extruding procedure, for example, a melt spinning or melt film-forming procedure, the large size of the particles causes the extruding pressure for the mixture to undesirably increase. Also, resultant product exhibits a poor drawability.

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The silicon dioxide fine particles are dispersed in at least a portion of the matrix located in a surface layer of the shaped substrate. The silicon dioxide fine particles may be uniformly distributed thoroughly in the polyester matrix in the shaped substrate. Otherwise, the silicon dioxide fine particles may be distributed only in a portion of the polyester matrix located in the surface portion of the shaped substrate.

30

The amount of the silicon dioxide fine particles is in the range of from 0.3 to 15%, by weight preferably, from 0.5 to 10%, based on the weight of the polyester matrix in which the fine particles are dispersed.

35

When the amount of the silicon dioxide fine particles is less than 0.3%, the resultant shaped substrate exhibits an unsatisfactory activity to the surface activating material and, therefore, resultant shaped polyester composite material exhibits a poor bonding property to rubber or other polymeric materials. Also, if the amount of the silicon dioxide fine particles is more than 15% by weight, the resultant mixture of the polyester matrix of the silicon dioxide fine particles exhibits a poor shaping and processing property. The shaped substrate of the present invention is not limited to a specific form of the substrate. Usually, the shaped substrate is in the form of a filament or fiber, or in the form of a film or sheet.

When the shaped substrate is in the form of a filament or fiber, the filament or fiber may be simple filament or fiber or composite filament or fiber. The simple filament or fiber may be a regular filament or fiber or a hollow filament or fiber made from a mixture of the polyester matrix and the silicon dioxide fine particles. The composite filament or fiber may be composed of a core portion thereof comprising an aromatic linear polyester alone, and a sheath portion thereof formed around the core portion and comprising the polyester matrix and the silicon dioxide fine particles. In this case, it is preferable that the weight of the sheath portion is in the range of 5 to 40% based on the entire weight of the filament or fiber substrate. Also, it is preferable that the aromatic linear polyester in the core portion exhibits an intrinsic viscosity of 0.6 or more, determined in o-chlorophenol at a temperature of 30°C.

In the case where the shaped substrate is in the form of a film or sheet, the silicon dioxide fine particles may be in both the surface portion or in either one surface portion of the film or sheet substrate.

In the shaped polyester composite material of the present invention, the surface coating layer is formed on the shaped substrate. The surface coating layer comprises

a surface-activating material consisting of at least one member selected from the group consisting of silane coupling compounds and organic titanium compounds, which has been heat-treated on the shaped substrate at a
5 temperature of 50°C or more but at least 10°C below the melting point of the polyester matrix.

The surface-activating material is effective for providing an activated surface of the shaped polyester composite material which exhibits an excellent bonding
10 property to rubber or other polymeric materials, when heat-treated on the surface of the silicon dioxide-containing shaped substrate at the above-specified temperature.

Usually, the amount of the surface activating material
15 is in the range of from 0.5 to 10% based on the weight of the shaped substrate.

When the amount of the surface-activating material is excessively small, usually, it is impossible to obtain a satisfactory bonding property of the resultant product to
20 rubber or other polymeric materials. Also, an excessive amount of the surface-activating material not only makes no contribution for increasing the bonding property of the resultant product but also, causes the cost of the resultant product to be excessively high.

25 The surface-activating material can be selected from the silane coupling compounds and organic titanium compounds which are capable of chemically bonding to the silicon dioxide fine particles embedded in the shaped substrate and of firmly bonding to the rubber or other
30 polymeric materials.

The silane coupling compounds are preferably of the formula (II):



wherein R represents a member selected from the group
35 consisting of vinyl, methacryl, allyl, epoxy, hydroxyl, amino and mercapto radicals and organic and inorganic functional radicals each having at least one chlorine atom,

and; X represents a member selected from the group consisting of organic and inorganic groups capable of reacting with siloxane radicals and/or silanol radicals.

The silane coupling compound may be selected from the group consisting of vinyl trichlorosilane, vinyl triethoxysilane, vinyl trimethoxysilane vinyl-tris(β -methoxyethoxy)-silane, γ -methacryloxypropyltrimethoxysilane, γ -methacryloxypropyl-tris(β -methoxyethoxy)silane, β -(3,4-epoxycyclohexyl)ethyltrimethoxysilane, γ -glycidoxypropyltrimethoxysilane, vinyl triacetoxysilane, γ -mercaptopropyltrimethoxysilane, γ -aminopropyltriethoxysilane, N- β (aminoethyl)- γ -aminopropyltrimethoxysilane, bis(β -hydroxyethyl)- γ -aminopropyltrimethoxysilane, γ -chloropropyltrimethoxysilane, N-(trimethoxysilylpropyl)diethylenetriamine, N-(trimethoxysilylpropyl) urea, carboethoxyethylaminopropyltriethoxysilane, chloromethylphenyltrimethoxysilane, phenylaminopropyltrimethoxysilane, aminophenyltrimethoxysilane, and N-(dimethoxymethylsilylpropyl)ethylenediamine.

When the silane coupling compound is applied onto the surface of the silicon dioxide-containing a shaped substrate, and heat-treated thereon at a specific temperature, the silane coupling compound reacts with the siloxane radicals and/or silanol radicals contained in the silicon dioxide fine particles located in the surface portion of the shaped substrate so that the silane coupling compound is fixed to the silicon dioxide fine particles. That is, the radical X in the silane coupling compound reacts with the siloxane radical in the silicon dioxide fine particles in the manner of a ring-opening addition, or the radical X reacts with the silanol radical in the silicon dioxide fine particles in the manner of a condensation or a dehydrochlorination. The reaction product has a number of free R radicals which exhibit a high degree of bonding activity to rubber or other polymeric materials, for example, polyester resins. That is, the R radical is capable of reacting with rubber or other polymeric materials in the manner of radical

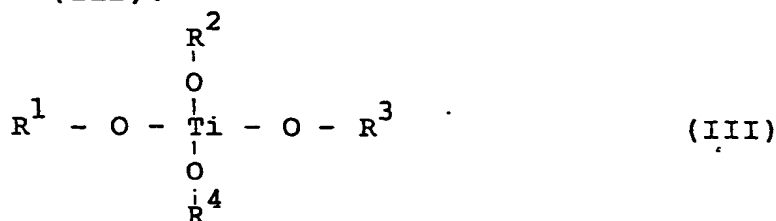
polymerization, ring-opening polymerization and/or dehydration condensation.

Accordingly, the silane coupling compound is effective for chemically coupling the surface of the shaped substrate
5 to the rubber or other polymeric materials.

The organic titanium compounds usable for the present invention are titanium compounds having at least one radical of the formula:



10 Usually, the organic titanium compounds are preferably, of the formula (III):



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wherein R^1 , R^2 , R^3 and R^4 respectively represents, independently from each other, a member selected from the group consisting of alkyl, alkenyl and acyl radicals each
20 having 2 to 24 carbon atoms.

The organic titanium compound may be selected from the group consisting of tetra-n-butyltitanate, tetrakis-(2-ethylhexyl)titanate, tetrastearyltitanate, iso-propyl-tri-iso-stearoyltitanate and iso-propyl-iso-stearoyl-
25 -dimethacroyltitanate.

The organic titanium compounds can activate the surface of the shaped substrate containing the silicon dioxide fine particles, in the following manner.

When the organic titanium compound is applied onto the
30 surface of the silicon dioxide-containing shaped substrate, and heat treated thereon at a specific temperature, at least one of the reactive radicals, $-\text{Ti}-\text{O}-\text{C}-$, in the titanate compound reacts with the siloxane and/or silanol radicals in the silicon dioxide fine particles so as to
35 form a group of the formula, $-\text{Ti}-\text{O}-\text{Si}-$. That is, the surface of the shaped substrate is covered with the titanium-containing reactive layer having the remaining

reactive radicals -Ti-O-C- and chemically fixed to the silicon dioxide fine particles. The remaining reactive radicals exhibit an enhanced bonding property to rubber and other polymeric materials. That is, the remaining reactive radicals -Ti-O-C- can react with rubber or other polymeric materials in the manner of radical polymerization, ring-opening polymerization and/or dehydration condensation.

The surface coating layer may contain an additional material comprising at least one polyepoxide compound, in addition to the surface-activating material, the additional material having been heat-treated on the shaped substrate at a specific temperature.

The polyepoxide compound usable for the present invention contains at least two epoxy groups per molecule of the compound, the amount of the epoxy groups in the compound being a gram equivalent of 0.2 or more per 100 g of the compound. The polyepoxide compound may be selected from the group consisting of reaction products of polyhydric alcohols with halogenated epoxide compounds, reaction products of polyhydric phenol compounds with halogenated epoxide compounds and oxidation products of unsaturated organic compounds having at least one aliphatic double bond with peracetic acid or hydrogen peroxide. The above-mentioned polyhydric alcohol may be selected from the group consisting of ethylene glycol, glycerol, diglycerol, diethylene glycol, sorbitol, pentaerythritol trimethylol propane, polyethylene glycols, and polypropylene glycols. Also, the above-mentioned halogenated epoxide compound is epichlorohydrine. The polyhydric phenol compound mentioned above may be selected from the group consisting of resorcin, catechol, 2,2-bis (4-hydroxyphenyl) propane, bis (4-hydroxyphenyl) dimethylmethane, phenol-formaldehyde resins and resorcin-formaldehyde resins. Furthermore, the above-mentioned oxidation product may be selected from the group consisting of 3,4-epoxycyclohexenepoxide, 3,4-epoxycyclohexylmethyl-3,4-epoxycyclohexene carboxylate and bis (3,4-epoxy-6-methyl cyclohexylmethyl) adipate. The

preferable polyepoxide compound for the present invention may be selected from polyglycidyl ethers of polyhydric alcohols, which are reaction products of polyhydric alcohols with epichlorohydrin.

5 The above-mentioned polyepoxide compound may be used in the state of an aqueous emulsion or solution for the process of the present invention. In order to prepare the aqueous emulsion or solution, the polyepoxide compound is directly, or optionally after dissolving it in a small
10 amount of a solvent, emulsified or dissolved in water, if necessary, in the presence of a surface active agent (emulsifying agent), for example, sodium alkylbenzene sulfonate.

It is preferable that the amount of the additional
15 material in the surface coating layer is in the range of 0.05 to 2% based on the weight of the shaped substrate.

When the polyepoxide compound is heat-treated at a temperature of 50°C or more, preferably, 150 to 260°C for 1 to 240 seconds, a portion of the polyepoxide compound
20 penetrates into the polyester matrix and, the epoxy rings in the polyepoxide compound located in and on the shaped substrate are opened, and the ring-opened compound is polymerized in and on the shaped substrate. Therefore, the polyepoxide compound is converted into a hardened polymer
25 firmly fixed in and on the shaped substrate. This hardened polymer is also effective for enhancing the bonding property of the shaped substrate to rubber or other polymeric materials.

The surface coating layer may contain, in addition to
30 the surface activating material and the additional material, a further additional material comprising at least one blocked polyisocyanate compound of the formula (IV):-



wherein Y represents a residue of a blocking compound which
35 residue is capable of dissociating from the blocked polyisocyanate when heat-treated, m represents an integer of 2 or more and A represents an m-valent radical, said further

additional material having been heat-treated on the shaped substrate at a specified temperature .

The blocked polyisocyanate compound usable for the present invention is an addition product of a polyisocyanate
5 compound with a blocking compound. When the blocked polyisocyanate compound is heated at an elevated temperature, the residue of the blocking agent is capable of dissociating from the blocked polyisocyanate.

The polyisocyanate compound may be selected from the
10 group consisting of tolylene diisocyanate, methaphenylene diisocyanate, diphenylene diisocyanate, hexamethylene diisocyanate, diphenylene diisocyanate, hexamethylene diisocyanate, polymethylenepolyphenyleneisocyanate, triphenylmethane triisocyanate, and polyalkyleneglycol-
15 -adduct polyisocyanates which are addition product of above-mentioned polyisocyanate compounds with polyol compounds having two or more activated hydrogen atoms, in the molar ratio of the isocyanate radicals to the hydroxyl radicals of 1:1. The preferable polyisocyanate can be
20 selected from aromatic polyisocyanate compounds, for example, tolylene diisocyanate, methaxylene diisocyanate, diphenylmethane diisocyanate and polymethylene polyphenylisocyanates.

The blocking compound can be selected from the group
25 consisting of phenol compounds; for example, phenol, thiophenol, cresol, resorcin; aliphatic tertiary alcohols, for example, tert-butyl alcohol and tert-pentyl alcohol; aromatic secondary alcohols; for example, diphenyl amine and xylidine; aromatic imides; for example, phthalic acid
30 imide; lactams, for example, caprolactam and valerolactam; oximes, for example, acetoxime, methylethylketoneoxime and cyclohexaneoxime, and; sodium hydrogen sulfite.

The further additional material is used preferably in an amount of 0.1 to 10% based on the weight of the shaped
35 substrate.

When the further additional material is heat-treated on the shaped substrate at a temperature of 50°C or more,

preferably, 100 to 250°C the blocked polyisocyanate compound is thermally decomposed so as to produce a compound having isocyanate radicals which are highly reactive to rubber or other polymeric materials. Therefore, the heat-treated blocked polyisocyanate compound is effective for enhancing the bonding property of the shaped substrate to rubber or other polymeric materials.

The surface coating layer may contain, in addition to the surface activating material, the additional material and the further additional material, a still further additional material comprising at least one rubber latex, the still further additional material having been heat-treated on the shaped substrate at the specified temperature.

The rubber latex may be selected from the group consisting of natural rubber latexes, styrene-butadiene copolymer latexes, butadiene-vinyl pyridine copolymer latexes, vinyl pyridine-styrene-butadiene terpolymer latexes, acrylonitrile rubber latexes acrylonitril-butadiene copolymer latexes and chloroprene rubber latexes.

The preferable rubber latex is one containing at least 50% by weight of a vinylpyridine-styrene-butadiene terpolymer.

The still further additional material is used preferably, in an amount of 0.1 to 10% based on the weight of the shaped substrate.

The shaped polyester composite material can be produced by the process of the present invention. In the first step of the process, a shaped substrate is prepared from a matrix-forming material consisting essentially of an aromatic linear polyester and fine solid particles comprising mainly silicon dioxide and having an average size of 5 to 100 millimicrons, the silicon dioxide fine solid particles being dispersed in at least a portion of the polyester matrix located in a surface portion of the shaped substrate and the amount of the fine particles being in the range of 0.3 to 15% based on the weight of the

polyester matrix in which the fine particles are dispersed.

In the preparation of the shaped substrate, the silicon dioxide fine solid particles may be mixed in any stage in the preparation procedure. For example, the
5 silicon dioxide fine particles can be mixed into a polymerization mixture for producing the matrix-forming polyester in any stage in the polymerization procedure, for example, in an esterification stage, in a condensation
10 stage or after the condensation is finished. Otherwise, the silicon dioxide fine solid particles may be blended with the polyester solid pellets or powder by a conventional mixing apparatus, and, then, the mixture may be melt-mixed by using an extruder. The silicon dioxide fine solid
15 resultant mixture may be melt-shaped into a desired form.

When the shaped substrate is a filament or fiber, which may be of either a regular type or a hollow type, the mixture of the polyester with the silicon dioxide fine particles is melt-spun through a spinneret having one or
20 more spinning holes and the resultant filament or filaments are drawn by a conventional polyester filament or fiber-producing method.

When the shaped substrate is a core-in-sheath type composite filament or fiber, the core portion of the
25 filament or fiber is made from an aromatic linear polyester alone, preferably having an intrinsic viscosity of 0.6 or more, and the sheath portion is made from a mixture of an aromatic linear polyester with the silicon dioxide fine particles. When the intrinsic viscosity of the polyester
30 in the core portion is less than 0.6, the resultant filament or fiber, sometimes, exhibits an unsatisfactory tensile strength, Young's modulus and a poor processability in the melt-spinning and/or drawing procedure. In the core-in-sheath type filament or fiber, it is preferable
35 that the amount of the sheath portion is 5% or more, more preferably in the range of from 5 to 40%, still more preferably, 10 to 30%, based on the entire weight of the

filament or fiber. When the amount of the sheath portion is less than 5% by weight, the core portion sometimes is exposed to the outside of the filament or fiber and, therefore, the resultant composite material exhibits an uneven bonding property to rubber or other polymeric material.

The filament or fiber may be in the form of a filament or fiber mass, multifilament yarn, monofilament yarn, spun yarn, thread, rope, cord, net, woven fabric, knitted fabric or non-woven fabric.

When the shaped substrate is in the form of a film or sheet, the mixture of the matrix-forming polyester with the silicon dioxide fine particles is melt-extruded through a T-die and if necessary, the resultant fiber or sheet is drawn at a desired draw ratio in one single direction or two directions at a right angle to each other. Also, the silicon dioxide-containing film or sheet may be handed to one or two surfaces of a base film or sheet comprising the aromatic linear polyester alone, so as to form a two- or three layer-polyester composite substrate.

The film or sheet may be in the form of a type yarn or split yarn or a sheet or net made from the tape yarn and/or split yarn.

In the process of the present invention, the surface of the shaped substrate, wherein the silicon dioxide fine particles are located, is coated with a surface coating liquid containing a surface-activating material consisting of at least one member selected from the group consisting of silane coupling compounds and organic titanium compounds, as described hereinbefore.

Usually, the specified surface-activating material is dissolved in a solvent which may consist of at least one member selected from the group consisting of water, methyl alcohol, ethyl alcohol, trichloroethane, toluene and n-hexane. In the surface coating liquid, it is preferable that the concentration of the surface-activating material is 0.5% by weight or more, more preferably, in the range of

from 0.5 to 20% by weight. When the concentration of the surface-activating material is less than 0.5% by weight, sometimes it is difficult to impart a desired intensity of the bonding property to rubber to the shaped substrate.

5 The coating procedure can be carried out by any conventional method, for example, dipping, spraying, brushing, roll coating or doctor knife coating method.

 The surface-coating product is heated, preferably at a temperature of 50 to 120°C so as to dry the layer of the
10 surface coating liquid formed on the shaped substrate and to provide a precursory composite material.

 The resultant precursory composite material is heat-treated at a temperature of 50°C or more, but at least 10°C below the melting point of the polyester matrix,
15 preferably, from 100 to 250°C.

 When the heat-treatment temperature is less than 50°C, the reaction rate of the surface activating material with the silicon dioxide fine particles is excessively low. When the heat-treatment temperature is above the point of
20 10°C below the melting point of the polyester matrix, the shaped substrate may be thermally deformed, for example, shrunk.

 The heat-treatment is usually carried out for a time period of 30 to 300 seconds. Preferably, the heat
25 treatment is carried out by placing the precursory composite material in a nitrogen atmosphere. However, the heat treatment may be carried out in air atmosphere or under vacuum. During the heat-treatment, the shaped substrate may be under a tensioned condition, tensionless
30 condition or relaxed condition.

 In the heat treatment procedure, the surface-activating material reacts with the siloxane radicals and/or silanol radicals in the silicon dioxide fine particles located on the surface of the shaped substrate. The resultant surface
35 of the shaped polyester composite material exhibits an enhanced bonding property to rubber or other polymeric materials.

The surface coating liquid may contain, in addition to the surface active material, an additional material comprising at least one polyoxide compound as described hereinbefore, preferably in an amount of 0.05 to 2% based on the weight of the shaped substrate.

Also, the surface coating liquid may contain, in addition to the surface-activating material and the additional material, a further additional material comprising at least one blocked polyisocyanate compound as described hereinabove, preferably, in an amount of 0.1 to 10% based on the weights of the shaped substrate.

Furthermore, the surface coating liquid may contain, in addition to the surface activating material, the additional material and the further additional material, a still further additional material comprising at least one rubber latex as described hereinbefore, preferably, in an amount of 0.1 to 10% based on the weight of the shaped substrate.

When the shaped polyester composite material is bonded to a rubber or other polymeric material, the surface of the composite material may be pre-treated with at least one pre-treating material, before the bonding procedure.

For example, in the core where the surface coating layer comprises the surface-activating material alone, the surface of the shaped polyester composite material may be coated with a first pre-treating material comprising at least one polyepoxide compound as described above, at least one blocked polyisocyanate compound as described above and at least one rubber latex as described above, and then, with a second pre-treating material comprising at least one ethylene urea compound, at least one resorcin-formaldehyde prepolymer or at least one rubber latex as described hereinbefore.

In the first pre-treating material, it is preferably that the amount of the polyepoxide compound is in the range of from 5 to 90%, more preferably, 10 to 50%, based on the sum of the weights of the polyepoxide compound and the

blocked polyisocyanate compound. Also, it is preferable that the amount of the rubber latex in the first pre-treating material is in the range of from 50 to 1500%, more preferably, 100 to 1000%, based on the sum of the weights of the polyepoxide compound and the blocked polyisocyanate compound.

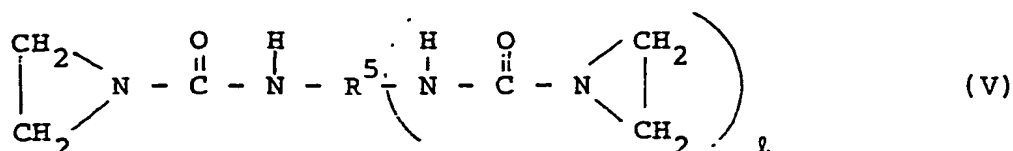
Usually, the first pre-treating material is dissolved, emulsified and/or dispersed in water, and the resultant first pre-treating liquid is applied onto the surface of the shaped polyester composite material. In this case, it is preferable that the total concentration of the first pre-treating material in the first pre-treating liquid is in the range of from 1 to 30%, more preferably, from 3 to 20% by weight.

The first pre-treating material may be emulsified or dispersed in water by using a proper surface active agent, such as an emulsifying or dispersing agent, in an amount of, preferably, 15% or less based on the total dry weight of the first treating composition. When the surface active agent is used in an amount larger than 15%, the resultant pre-treated product may tend to have a relatively poor bonding property to rubber.

The layer of the first pre-treating liquid formed on the surface of the shaped polyester composite material is dried at a temperature of 50 to 120°C and the resultant product is heat-treated at a temperature of 180°C or more, but not exceeding the melting point of the polyester matrix, preferably, 220 to 250°C.

It is preferable that the dry weight of the resultant layer of the first pre-treating material is in the range of from 0.1 to 10%, more preferably, from 0.5 to 5% based on the weight of the shaped substrate.

The first pre-treated product is further pre-treated with the second pre-treating material. The second pre-treating material contains at least one ethylene urea compound of the formula.(V):



5 wherein R^5 stands for an aromatic or aliphatic hydrocarbon residue and ℓ is 0, 1 or 2.

The ethylene urea compound of the formula (V) may be a reaction product of ethyleneimine with an isocyanate selected from the group consisting of octadecylisocyanate, 10 hexamethylenediisocyanate, isophoronediiisocyanate, tolylenediisocyanate, methaxylenediisocyanate, diphenylmethanediisocyanate, naphthylenediisocyanate, and triphenylmethanetriisocyanate.

Also, the second pre-treating material contains at 15 least one resorcin-formaldehyde prepolymer. The resorcin-formaldehyde prepolymer usable for the second pre-treatment is an initial product of a condensation reaction of resorcin with formaldehyde preferably at a molar ratio of from 1:0.1 to 1:8, more preferably, from 1:0.5 to 1:5, 20 still more preferably, from 1:1 to 1:4 in the presence of an alkali catalyst or an acid catalyst.

When heat-treated at a temperature of 120°C or more, preferably, 100 to 250°C, for 30 to 300 seconds, the resorcin-formaldehyde prepolymer is converted into a 25 completely polymerized resin.

Furthermore, the second pre-treating material contains at least one rubber latex as described hereinabove. The preferably rubber latex is a latex of a rubber material containing at least 50% by weight of a vinyl pyridine- 30 -styrene-butadiene terpolymer.

In the above-mentioned second pre-treating material, it is preferably that the ratio in weight of the resorcin-formaldehyde prepolymer to the rubber latex is in a range of from 1:1 to 1:15, more preferably, from 1:3 to 35 1:12, and that the amount of the ethylene urea compound is in the range of from 0.5 to 30%, more preferably, 1.0 to 20% based on the sum of the weights of the

resorcin-formaldehyde prepolymer and the rubber latex.

The mixture of the resorcin-formaldehyde prepolymer and the rubber latex may be aged at a temperature of 15 to 25°C for 15 hours or more before the ethylene urea compound is mixed thereto.

The second pre-treating material is dissolved, dispersed or emulsified in a liquid medium, that is, water, to provide a second pre-treating liquid containing 10 to 25% by dry weight of the second pre-treating material.

After the second pre-treating liquid is applied onto the surface of the first pre-treated product, the resultant layer of the second pre-treating liquid formed on the first pre-treated product is dried at a temperature of 50 to 120°C. Thereafter, the resultant second pre-treated product is heat-treated at a temperature of 120°C or more, but not exceeding the melting point of the polyester matrix, preferably, from 180 to 250°C. The resultant pre-treated composite product exhibits an enhanced bonding property to rubber or other polymeric materials.

In the case where the surface coating layer on the shaped substrate contains the polyepoxide compound, the blocked polyisocyanate compound and the rubber latex in addition to the surface-activating material, the surface of the surface coating layer may be coated with a pre-treating material having the same composition as that of the above-mentioned second pre-treating material. In another example of the pre-treatment, in the case where the surface coating layer contains the surface-activating material alone, the surface of the surface coating layer in the composite material is first pre-treated with a first pre-treating material consisting of at least one polyepoxide compound as described hereinbefore, and, then, with a second pre-treating material comprising the resorcin-formaldehyde prepolymer and the rubber latex as described hereinabove.

The polyepoxide compound is used in the form of an

aqueous solution, emulsion or dispersion containing 0.5 to 10%, preferably, 1.0 to 5.0% by dry weight of the polyepoxide compound. The first pre-treated product preferably contains 0.1 to 10%, based on the weight of the
5 shaped substrate, of the polyepoxide compound.

After the first pre-treating liquid is applied onto the surface of the composite material and dried, the resultant product is heat-treated at a temperature of 120°C or more, but not exceeding the melting point of the
10 polyester matrix, preferably, 220°C to 250°C.

In the second pre-treating material, the ratio in weight of the resorcin-formaldehyde prepolymer to the rubber latex is preferably in the range of from 1:1 to 1:15, more preferably, from 1:3 to 1:12.

15 The second pre-treating material is used in the form of an aqueous emulsion or solution containing 10 to 25% by dry weight of the mixture of the resorcin-formaldehyde prepolymer and the rubber latex. After the second pre-treating liquid is applied onto the first pre-treated
20 product and dried, the resultant product is heat-treated at a temperature of 120°C or more, but not exceeding the melting point of the polyester matrix, preferably, from 180 to 250°C.

In the case where the surface coating layer on the
25 shaped substrate contains the polyepoxide compound in addition to the surface-activating material, this type of the shaped polyester composite material is pretreated with a pre-treating material containing the resorcin-formaldehyde prepolymer and the rubber latex in the same composition as
30 that described above. This type of pre-treatment is useful for the case wherein the shaped substrate in the shaped polyester composite material is in the form of a core-in-sheath type composite filament or fiber.

In still another example of the pre-treatment, in the
35 case where the surface coating layer comprises the surface-activating material alone, the shaped polyester composite material is pre-treated with a first pre-treating

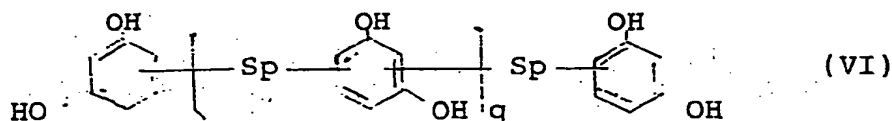
material comprising at least one polyepoxide compound and at least one blocked polyisocyanate compound as described hereinabove, and, then, with a second pre-treating material comprising at least ethylene urea compound of the

5 formula (V) a prepolymer of a mixture of resorcin with a sulfur-modified resorcin with formaldehyde and a rubber latex.

In the first pre-treating material, the amount of the polyepoxide compound is preferably in the range of from 5
10 to 90%, more preferably, from 10 to 50%, based on the sum of the weights of the polyepoxide compound and the blocked polyisocyanate compound.

The first pre-treating material is used in the form of an aqueous solution, emulsion or dispersion containing 1
15 to 30% by dry weight of the first pre-treating material. When the first pre-treating liquid is applied to the shaped polyester composite material, it is preferable that the first pre-treating material is fixed in a dry weight of 0.1 to 10%, more preferably, 0.5 to 5% based on the weight of
20 the shaped substrate, onto the surface of the shaped polyester composite material. For the fixing, the first pre-treated product is heat-treated at a temperature of 180°C or more, but not exceeding the melting point of the polyester matrix, preferably, from 220 to 250°C.

25 In the second pre-treating material, the prepolymer of the mixture of resorcin and the sulfur-modified resorcin with formaldehyde is of the formula (VI):



wherein p is an integer of 1 to 8 and q is 0 or an integer of 1 to 15.

The sulfur-modified resorcin can be produced by reacting resorcin with sulfur chloride in a reaction medium
35 which is not reactive to sulfur chloride.

In the prepolymer, the molar ratio of the mixture of resorcin and the sulfur-modified resorcin to formaldehyde

is usually in the range of 1:0.1 to 1:8, preferably, 1:1 to 1:4.

In the second pre-treating material, the ethylene urea compound is contained in an amount of 0.5 to 30%, preferably, 1.0 to 20%, based on the dry weight of the sum of the prepolymer and the rubber latex. Also, the weight ratio of the prepolymer to the rubber latex is preferably in the range of 1:1 to 1:15, more preferably, 1:3 to 1:12.

The second pre-treating material is used in the form of an aqueous solution, emulsion or dispersion containing 10 to 25% by dry weight of the second pre-treating material. After being applied onto the first pre-treated product, the product is dried and, then, heat-treated at a temperature of 120°C or more, but not exceeding the melting point of the polyester matrix, preferably, 180 to 250°C. It is preferable that the pretreated product contains 0.5 to 15%, more preferably, 1 to 5% by dry weight of the heat-treated second pre-treating material.

In the case where the surface coating layer on the shaped substrate contains the polyepoxide compound and the blocked polyisocyanate compound as described hereinabove, in addition to the surface-activating material, the surface of the shaped polyester composite material is pre-treated with a pre-treating material having the same composition as that of the above-mentioned second pre-treating material.

In still another example of the pre-treatment, in the case where the surface coating layer in the shaped polyester composite material contains the polyepoxide compound as described hereinabove, in addition to the surface-activating material, the shaped polyester composite material is pre-treated with a pre-treating material comprising the blocked polyisocyanate, the ethylene urea compound of the formula (V), the prepolymer of the formula (VI) of a mixture of resorcin and sulfur-modified resorcin with formaldehyde and the rubber latex as described hereinabove.

In the pre-treating material, the amount of the blocked polyisocyanate is preferably, in the range of 0.5

to 25% more preferably, 5 to 15% based on the dry weight of the sum of the prepolymer and the rubber latex, and the amount of the ethylene urea compound is preferably in the range of 0.5 to 30%, more preferably 1.0 to 20% based on
5 the dry weight of the sum of the prepolymer and the rubber latex. Also, the mixing ratio in weight of the prepolymer to the rubber latex is preferably in the range of from 1:1 to 1:15, more preferably, from 1:3 to 1:12.

The pre-treating material is used in the form of a
10 pre-treating liquid containing 10 to 25% by dry weight of the pre-treating material. The heat-treatment for the pre-treating material is carried out at a temperature of 120°C or more, but not exceeding the melting point of the polyester matrix, preferably, 180 to 250°C.

15 The heat-treated product preferably contains 0.5 to 10%, more preferably, 1 to 5% by dry weight of the pre-treating material.

In the above-mentioned type of pre-treatment, either one or both of the blocked polyisocyanate compound and the
20 ethylene urea compound of the formula (V) may be omitted from the pre-treating material.

In another example of the pre-treatment, in the case where the surface coating layer on the shaped substrate contains the polyepoxide compound as described hereinabove,
25 in addition to the surface-activating material, the shaped polyester composite material is pre-treated with a pre-treating material comprising the ethylene urea compound of the formula (V), the resorcin-formaldehyde prepolymer and the rubber latex as described hereinabove.

30 In the pre-treating material, the amount of the ethylene urea compound is preferably in the range of from 0.5 to 30%, more preferably from 1.0 to 20% based on the sum of the dry weights of the prepolymer and the rubber latex, and the mixing ratio in dry weight of the prepolymer
35 to the rubber latex is preferably in the range of 1:1 to 1:15, more preferably 1:3 to 1:12.

The pre-treating material used is in the form of a

pre-treating liquid containing 10 to 25% by dry weight of the pre-treating material. The heat-treatment for the pre-treating material is carried out at a temperature of 120°C or more, but not exceeding the melting point of the polyester matrix, preferably, from 180 to 250°C. After the heat-treatment, the resultant product contains the heat-treated pre-treating material, preferably in the amount of 0.5 to 10%, more preferably 1 to 5% by weight.

The specific examples presented below will serve to more fully explain how the present invention is practiced. However, it will be understood that these examples are only illustrative and in no way limit the present invention.

In the examples, the following tests were carried out on the resultant products.

1. Peeling resistance

Two tire cords each having a density of 27 threads/2.54 cm were superimposed on each other at an angle of 90 degrees from each other and treated in accordance with the process of the present invention. The resultant reinforcing ply was embedded within a rubber composition for producing a carcass of a tire for an automobile. The rubber composite article thus prepared was subjected to a vulcanizing operation in a press at a temperature of 160°C for 20 minutes.

In order to determine the bonding strength of the reinforcing ply to rubber, the reinforcing ply was peeled off from the rubber matrix at a rate of 200 mm/minute. The load required to peel off the reinforcing ply from the rubber matrix was shown in a unit of kg/3 cm.

2. Rubber coverage

After the above-mentioned reinforcing ply was peeled off from the rubber matrix, the surface of the reinforcing ply was observed with the naked eye, and the percentage of a total area of the portions of the reinforcing ply surface covered by the rubber based on the whole area of the surface was determined.

3. Resistance to bending

The resistance of the above-mentioned reinforcing ply to bending was determined by using a Gurley type stiffness tester disclosed in U.S. Patent No. 3,575,761.

5 4. Heat resistance in rubber matrix

A test specimen (cord) was embedded in a rubber matrix and vulcanized at a temperature of 170°C for 3 hours. Thereafter, the test specimen was removed from the rubber matrix. The tensile strength (X_0) of the specimen before
10 testing was determined, and after the completion of the testing process, the remaining tensile strength (X_1) of the specimen was determined. The percentage of the remaining tensile strength of the specimen after the testing process based on that before testing was calculated in accordance
15 with the equation:

$$\text{Remaining tensile strength(\%)} = \frac{X_1}{X_0} \times 100$$

20 5. T-bonding strength

A cord embedded at a depth of 1 cm within a rubber block and the cord-containing rubber block was vulcanized at a temperature of 150°C for 30 minutes while being pressed.

In order to determine the T-bonding strength of
25 the cord to rubber, the cord was pulled out from the rubber block at a speed of 200 mm/min.

The T-bonding strength of the cord to rubber was represented by the load in kg/cm necessary to pull out the cord from the rubber block.

30 6. CRA-bonding strength

Five cords were embedded within a surface layer of a rubber sheet and the cord-containing rubber sheet was vulcanized at a temperature of 150°C for 30 minutes while being pressed.

35 In order to determine the CRA-bonding strength, the five cords were peeled from the surface layer of the rubber sheet at a rate of 200 mm/min. The CRA-bonding

strength of the cords to the rubber sheet was represented by the load, in kg/5 cords, applied to the cords.

Examples 1 through 13 and Comparative

Examples 1 through 3

5 In each of the Examples 1 through 13 and Comparative Examples 1 through 3, a multifilament yarn having a yarn count of 1280 dtex/192 filaments was prepared from a mixture of an amount, as indicated in Table 1, of silicon dioxide fine particles having an average size as indicated
10 in Table 1 and the balance consisting of a polyethylene terephthalate having an intrinsic viscosity $[\eta]$ of 0.64 and a melting point of 260°C, by a usual melt-spining-drawing process.

 The multifilament yarn was converted into a cord which
15 was composed of three yarns, each having a first twisting number of 40 turns/10 cm, by finally twisting the three yarns altogether at a ply twisting number of 40 turns/10 cm. The resultant cord was of a yarn count of 4444 dtex/576 filaments. The cord was treated with methyl alcohol and
20 dried at a temperature of 70°C for 180 seconds.

 Separately, a surface coating liquid was prepared by dissolving 3% by weight of a silane coupling compound, as indicated in Table 1, in toluene.

 The cord was immersed in the surface coating liquid,
25 withdrawn therefrom, dried at a temperature of 100°C for 120 seconds and finally, heat-treated at a temperature of 120°C for 120 seconds. The dried cord contained 1.5%, based on the weight of the cord, of the silane coupling compound.

30 The resultant polyester composite cord was subjected to the tests for heat resistance in a rubber matrix, CRA-bonding strength, T-bonding strength and peeling resistance. The results are indicated in Table 1.

Table 1

Example No.	Silicon dioxide fine particles		Silane coupling compound	Heat resistance in rubber matrix (%)	CRA-bonding strength (kg/5c)	T-bonding strength (kg/cm)	Peeling resistance (kg/3cm)
	Average size (μ)	Amount (% by wt.)					
Example 1	5	0.5	Vinyl trichlorosilane	68	11.3	14.0	21.0
Example 2	10	0.5	"	69	11.2	13.9	20.5
Example 3	20	0.5	"	71	11.5	14.2	20.5
Example 4	50	0.5	"	72	11.5	14.4	21.0
Example 5	90	0.5	"	72	11.5	14.0	22.0
Comparative Example 1	110	0.5	"	Failed to melt-spin			
Comparative Example 2	10	0.2	"	62	11.2	12.2	18.5
Example 6	10	0.5	"	69	11.2	13.9	20.0
Example 7	10	1.0	"	72	11.5	14.2	20.0
Example 8	10	13.0	"	72	12.8	16.0	25.0
Comparative Example 3	10	16.0	"	65	12.5	14.2	20.0 (*)
Example 9	10	0.5	"	69	11.2	13.9	20.0
Example 10	10	0.5	Vinyl ethoxysilane	69	11.3	13.5	21.0
Example 11	10	0.5	γ-glycidypropyltrimethoxysilane	70	11.7	14.2	25.0
Example 12	10	0.5	N-p-(aminoethyl)-γ-aminopropyl-trimethoxysilane	65	11.0	12.1	21.5
Example 13	10	0.5	γ-mercaptopropylmethoxysilane	68	11.8	14.0	24.5

Note: (*) The cord exhibited a poor tensile strength

Examples 14 through 17 and Comparative
Examples 4 and 5

In each of Examples 14 through 17 and Comparative Examples 4 and 5, a film having a thickness of 0.03 mm was
5 prepared from a mixture of 0.5% by weight of silicon dioxide fine particles having an average size of about 10 millimicrons and the balance consisting of a polyethylene terephthalate having an intrinsic viscosity of 0.64 and a
10 melting point of 260°C by a usual film-forming process in which an extruder with a T-die was used and the extruded film was drawn biaxially.

The film was immersed in a surface coating liquid containing 3% by weight of γ -glycidoxypyrpyltrimethoxysilane dissolved in toluene. The film was withdrawn from the
15 surface coating liquid. The film was coated by 2%, based on the weight of the film, of the surface coating liquid. The coated film was dried and heat-treated at a temperature as indicated in Table 2 for 60 seconds.

The resultant polyester composite film was embedded
20 within a rubber composition for producing a carcass of a tire and vulcanized at a temperature of 120°C for 90 minutes. The resistance of the composite film to peeling from the rubber matrix was measured. The result is indicated in Table 2.

Table 2

Example No.		Silane coupling compound Type	Heat-treatment temperature (°C)	Peeling resistance (kg/3cm)
Comparative Example	4	γ -glycidoxypropyltrimethoxysilane	40	26.5
	14	"	60	28.0
	15	"	130	28.0
	16	"	180	28.5
	17	"	230	28.0
Comparative Example	5	"	250	20.0

Examples 18 through 23 and Comparative Examples 6 through 11

20 In Example 18, the same polyester multifilament as that described in Example 2 was surface coated with a surface coating liquid containing 5% by weight of γ -glycidoxypropyltrimethoxysilane dissolved in toluene, so that 2% by dry weight of the γ -glycidoxypropyltrimethoxy-

25 silane was picked up by the cord. The coated cord was dried and heat-treated at a temperature of 180°C for 60 seconds. The resultant coated cord was subjected to the tests for the CRA-bonding strength and T-bonding strength.

In Example 19, the same procedures as those described

30 in Example 18 were carried out, except that the heat-treated cord was pre-treated with a pre-treating liquid containing a pre-treating material consisting of a resorcin-formaldehyde prepolymer, vinyl pyridine-styrene-butadiene terpolymer latex and diphenylmethane diethylene

35 urea, so that 4.5% by total dry weight of the pre-treating material was picked up by the cord. The cord was dried at a temperature of 100°C for 120 seconds and heat-treated at

a temperature of 230°C for 60 seconds.

In Comparative Example 6, a cord prepared from the multifilament yarn which was the same as that described in Example 2 but not containing the silicon dioxide fine
5 particles, in the same manner as that described in Example 1, was surface coated in the same manner as that described in Example 18.

In Comparative Example 7, the same procedures as those described in Comparative Example 6 were carried out, except
10 that the resultant surface coated cord was pre-treated in the same manner as that described in Example 19.

In Example 20, the same procedures as those described in Example 18 were carried out, except that N-(β -aminoethyl)- γ -aminopropyltrimethoxysilane was used as the silane
15 coupling compound.

In Example 21, the same procedures as those described in Example 19 were carried out, except that the same silane coupling compound as that described in Example 20 was used.

In Comparative Example 8, the same procedures as those
20 described in Comparative Example 6 were carried out, except that the same silane coupling compound as described in Example 20 was used.

In Comparative Example 9, the same procedures as those described in Comparative Example 7 were carried out, except
25 that the same silane coupling compound as mentioned in Example 20 was used.

In Example 22, the same procedures as those described in Example 18 were carried out, except that γ -mercaptopropyl-trimethoxysilane was used as the silane coupling compound.

30 In Example 23, the same procedures as those described in Example 19 were carried out, except that the same silane coupling compound as mentioned in Example 22 were used. -

In Comparative Example 10, the same procedures as those described in Comparative Example 6 were carried out,
35 except that the same silane coupling compound as mentioned in Example 22 were used.

In Comparative Example 11, the same procedure as those

mentioned in Comparative Example 7 were carried out except that the same silane coupling compound as mentioned in Example 22 was used.

The results of the tests are indicated in Table 3.

Table 3

Example No.		CRA-bonding strength (kg/5c)	T-bonding strength (kg/cm)
Comparative Example	6	5.9	7.5
	7	7.5	10.0
Example	18	8.0	9.8
	19	11.1	17.6
Comparative Example	8	5.8	7.4
	9	7.4	9.2
Example	20	6.3	8.4
	21	9.6	15.4
Comparative Example	10	5.8	7.6
	11	6.6	10.0
Example	22	7.8	9.2
	23	10.8	16.8

30 Examples 24 through 27 and Comparative Example 12

In Examples 24 through 27, a multifilament yarn having a yarn count of 1070 dtex/192 filaments was produced from an amount, as indicated in Table 4, of silicon dioxide fine particles having an average size as indicated in Table 4

35 and the balance consisting of a polyethylene terephthalate having an intrinsic viscosity of 0.64 by the usual melt-spinning-drawing process.

The multifilament yarn was connected into a cord having a yarn count of about 3330 dtex/576 filament in the same manner as that described in Example 1.

5 The cord was impregnated with a surface coating liquid containing 5% by weight of γ -glycidoxypropyltrimethoxysilane in water, and, then, dried and heat-treated at a temperature of 120°C for 120 seconds. The dry weight of the silane coupling compound picked up by the cord was 0.8% based on the weight of the cord.

10 A first pre-treating liquid was prepared by the following procedures.

6 g of sorbitol polyglycidylether which was available under the trademark of DENACOL EX-611 from NAGASE SANGYO CO., JAPAN, was mixed with 4 g of a 30% aqueous solution of sodium dioctylsulfosuccinate which was available under the trademark of NEOCOL SW-30 from DAIICHI KOGYO SEIYAKU CO., JAPAN. The mixture was added to 805 g of water while vigorously stirring the resultant admixture to dissolve DENACOL EX-611 in water.

20 Separately, 14 g of 4,4'-diphenyl methane diisocyanate-phenol blocking product which was available under the trademark of Hylene MP from Du Pont, 4 g of NEOCOL SW-30 and 42 g of water were mixed by using a ball mill for 24 hours. The resultant dispersion was mixed with the above-mentioned DENACOL EX-611 solution and 125 g of a 40% aqueous emulsion of vinyl pyridinestyrene-butadiene terpolymer which was available under the trademark of NIPPOL 2518 FS from NIPPON ZEON CO., JAPAN. The resultant mixture was used as the first pre-treating liquid 60 g of a 40% solution of a prepolymer of resorcin and formaldehyde in acetone which was prepared by using an acid catalyst, were added to an aqueous solution of 10 g of a 10% aqueous solution of sodium hydroxide and 30 g of a 28% aqueous solution of ammonia in 260 g of water, while stirring the mixture.

35 Separately, a mixture was prepared by mixing 240 g of NIPPOL 2518 FS and 100 g of a 40% aqueous emulsion of a

styrene-butadiene copolymer which was available under the trademark of NIPPOL LX-112 from NIPPON ZEON, with 200 g of water.

The above-mentioned resorcin-formaldehyde prepolymer
5 liquid was gradually mixed with the above-mentioned mixture and 20 g of a 37% aqueous solution of formaldehyde. The resultant mixture was further mixed with an aqueous dispersion which was prepared by mixing 20 g of diphenylmethane diethylene urea, 7 g of NEOCOL SW-30 and 53 g water
10 in a ball mill for 24 hours. The resultant aqueous liquid was used as a second pre-treating liquid.

The surface-coated cord was impregnated with the first pre-treating liquid by using a tire cord-treating machine, dried at 150°C for 2 minutes and, then, heat treated at
15 230°C for one minute. The amount of the first pre-treating material picked up by the cord was 2.2% by dry weight based on the weight of the cord.

The first pre-treated cord was further pre-treated with the second pre-treating liquid, and dried and heat
20 treated in the same manner as that mentioned above. The amount of the second pre-treating material picked up by the cord was 2.5% by dry weight based on the weight of the cord.

The resultant product was subjected to the tests as
25 indicated in Table 4. The results are indicated in Table 4.

Table 4

Example No.	Silicon dioxide fine particles		Surface coating with silane compounding compound	Composition of first pre-treating liquid (wt%)			Second pre-treating material	Results of Tests					
	Average size (m μ)	Amount (% by wt.)		Poly epoxide	Blocked polyiso-cyanate	Rubber latex		Heat resistance (%)	CRB-bonding strength (kg/5c)	T-bonding strength (kg/cm)	Peeling resistance (kg/3cm)	Rubber coverage (%)	Resistance to bending (mg)
Example 24	10	0.8	yes	0.6	1.4	5.0	RFL+ diphenyl-methane diethylene urea	85	12.5	17.0	32	90	2500
Comparative Example 12	10	0.8	no	0.6	1.4	5.0	RFL+ diphenyl-methane diethylene urea	55	6.5	11.0	16	50	3500
Example 25	90	0.8	yes	0.6	1.4	5.0		80	12.0	16.5	31	85	2000
26	10	13	"	0.6	1.4	5.0		85	12.5	17.0	32	90	2200
27	5	0.8	"	0.6	1.4	5.0		80	12.2	17.0	31	90	2100

Examples 28 through 31

In each of the Examples 28 through 31, the same procedures as those described in Example 24 were carried out except that the γ -glycidoxypropyltrimethoxysilane was replaced by the silane coupling compound as indicated in Table 5.

The results of the tests are indicated in Table 5.

Table 5

Example NO.	Silane coupling compound	Heat resis- tance (%)	CRA- bonding strength (kg/5c)	T- bonding strength (kg/cm)	Peeling resist- ance (kg/3cm)	Rubber cover- age (%)	Re- sistance to bending (mg)
28	Vinyl trichlorosilane	80	12.0	16.5	31	30	2500
29	N- β (aminoethyl)- γ - aminopropyl- trimethoxysilane	70	11.5	16.0	28	80	2900
30	n-mercaptopropyl- trimethoxysilane	85	12.5	17.0	30	85	2100
31	Vinyl ethoxysilane	80	12.0	16.5	31	90	2200

Examples 32 through 35

In each of Examples 32 through 35, the same procedures as those mentioned in Example 24 were carried out, except that the polyepoxide compound, the blocked polyisocyanate compound or the rubber latex was replaced by the substance as indicated in Table 6.

The results of the tests were indicated in Table 6.

Table 6

Example No.	Compound	Heat resistance (%)	CRA-bonding strength (kg/5c)	T-bonding strength (kg/cm)	Peeling resistance (kg/3cm)	Rubber coverage (%)	Resistance to bending (mg)
32	Pentaerythritol diglycidylether (Polyepoxide)	85	12.5	17.0	31	85	2600
33	4,4'-diphenylmethane di-iso-cyanate- ϵ -caprolactam blocking product (Blocked polyisocyanate)	80	12.0	16.5	29	85	2500
34	Polymethylene-polyphenylisocyanate-phenol blocking product (Blocked polyisocyanate)	85	12.3	16.0	30	90	2300
35	Styrene-butadiene copolymer (Rubber later)	80	12.0	16.5	31	85	2200

Examples 36 through 38

In each of the Examples 36 through 38, the same procedures as those described in Example 24 were carried out, except that the diphenylmethane diethylene urea was replaced by the compounds as indicated in Table 7. The results of the tests are indicated in Table 7.

Table 7

Example No.	Ethylene urea compound	Heat resistance (%)	CRA-bonding strength (kg/5c)	T-bonding strength (kg/cm)	Peeling resistance (kg/3cm)	Rubber coverage (%)	Resistance to bending (mg)
36	Toluene diethylene urea	85	12.0	16.5	31	90	2200
37	Hexamethylene diethylene urea	80	11.8	17.0	30	90	2300
38	Triphenylmethan triethylene urea	80	12.5	16.5	30	90	2100

Examples 39 through 42

In the Examples 39 through 42, the same procedures as those of Examples 24, 25, 26, and 27 were respectively carried out except that the surface coating liquid contained additional components corresponding to the components of the first pre-treating liquid, in addition to the surface-activating material, that is, γ -glycidoxypropyl-trimethoxysilane, and that the first pre-treatment was omitted. In each example, the total amount of the additional components picked up by the cord was 6% based on the weight of the cord, and the ratio in dry weight of the surface activating material to the additional component was 1:1.

The results of the tests are indicated in Table 8.

Table 8

Example No.	Heat resis- tance (%)	CRA- bonding strength (kg/5c)	T- bonding strength (kg/cm)	Peeling resis- tance (kg/3cm)	Rubber cover- age (%)	Resistance to bending (mg)
39	85	12.0	17.0	31	90	2100
40	80	12.5	16.5	29	85	2500
41	85	12.0	16.5	30	90	2200
42	80	12.0	17.0	30	90	2400

15 Examples 43 through 49 and Comparative
Examples 13 through 22

20 In each of the Examples 43 through 49 and Comparative
Examples 13 through 22, a multifilament yarn having a yarn
count of 1670 dtex/192 filaments was prepared from an
amount, as indicated in Table 10, of silicon dioxide fine
particles having an average size indicated in Table 10, and
the balance consisting of a polyethylene terephthalate
having an intrinsic viscosity of 0.64, by a usual
melt-spinning and drawing process.

25 During the melt-spinning procedure, the resultant
multifilament yarn was coated with a surface coating liquid
having a composition as indicated in Table 9, so that 0.5%
by dry weight of the surface coating material was picked up
by the yarn. The surface coated yarn was dried and then,
30 drawn at a temperature of 230°C.

The drawn multifilament yarn was first twisted at a
first twisting number of 40 turns/10 cm. A cord was
prepared by ply-twisting two of the above-first twisted
multifilament yarn together at a ply-twisting number
35 of 40 turns/10 cm. The resultant cord had a yarn count of
about 3340 dtex/384 filaments.

The cord was impregnated with a pre-treating liquid

which was prepared by mixing 22 g of resorcin, 29 g of a 37% aqueous solution of formaldehyde, 31 g of a 28% aqueous solution of ammonia and 500 g of water at a temperature of 25°C for 3 hours while stirring the mixture, by further the
 5 resultant solution of resorcin-formaldehyde prepolymer with 418 g of NIPPOL 2518FS at a temperature of 25°C for 48 hours while stirring the mixture to prepared an RFL emulsion.

The resultant product was subjected to the tests for
 10 CRA-bonding strength, T-bonding strength and resistance to peeling. In each test, the vulcanization was carried out at a temperature of 150°C for 30 minutes or at a temperature of 170°C for 90 minutes. The results of the tests are indicated in Table 10.

Table 9

Component	Type of surface coating composition (% wt)					
	A	B	C	D	E	F
Polyepoxide compound DENACOL EX-421 (*)1	15	20	25	30	40	50
Silane coupling compound γ-glycidoxypropyltrimethoxysilane	15	20	25	-	-	-
Surface active agent						
Diocetyl acetate	35	25	15	35	25	15
POE(10)-lauryl amine	7.5	7.5	7.5	7.5	7.5	7.5
Oleic acid	2.5	2.5	2.5	2.5	2.5	2.5
POE(18)-hardened castor oil ether	12	12	-	12	12	-
POE(3)-Sodium laurylsulfate	-	-	2.5	-	-	2.5
POE(3) laurylether	6	6	15	6	6	15
POE(3) nonylphenol	7	7	7.5	7	7	7.5

Note: (*)1 — Trademark of a polyepoxide resin made by
 NAGASE SANGYO CO., JAPAN

Table 10

Example No.	Silicon dioxide fine particles		Type of Surface coating Compo- sition (*)2	Heat re- sistance (%)	CRA-bonding strength (kg/5C)			T-bonding strength (kg/cm)			Resistance to peeling (kg/3 cm)		
	Average size (μ m)	Amount (% wt)			Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	
Example 43	10	0.8	A	85	11.2	9.2	16.5	11.5	11.5	31	28		
	10	0.8	B	80	11.5	9.1	16.2	12.0	12.0	30	27		
	10	0.8	C	85	11.1	9.5	16.8	11.8	11.8	31	27		
Comparative Example 44	10	0.8	D	65	10.9	5.5	16.2	7.6	7.6	30	18		
	10	0.8	E	60	10.8	5.8	16.0	8.0	8.0	29	18.5		
	10	0.8	F	65	11.0	5.6	16.3	7.8	7.8	30	17.0		
Comparative Example 45	10	13.0	A	85	11.5	9.2	16.5	11.2	11.2	31	27.5		
	10	16.0	A	70	10.5	5.0	15.5	7.5	7.5	29	16.5		
	5	0.8	A	85	12.0	9.0	16.0	10.8	10.8	30	26.5		
Example 47	50	0.8	A	85	11.5	9.3	16.9	11.1	11.1	31	26		
	90	0.8	A	80	11.8	9.2	16.5	11.2	11.2	30	25.5		
	0	0	A	65	8.5	3.2	12.1	6.0	6.0	31	19		
Comparative Example 17	0	0	B	60	8.2	4.6	12.0	4.9	4.9	30	18		
	0	0	C	60	9.0	4.0	12.5	5.6	5.6	30	18		
	0	0	D	60	11.1	5.2	16.1	8.1	8.1	31	17		
Comparative Example 18	0	0	E	60	11.3	5.0	16.0	7.5	7.5	30	12		
	0	0	F	60	10.9	4.6	15.8	7.5	7.5	32	19		

Note: (*)2 — Refer to Table 9

Examples 50 through 52 and Comparative
Examples 23 through 25

In each of the Example 50 through 52, the same cord as that described in Example 43 was surface coated with a surface coating liquid containing 3% by weight of a surface coating material consisting of the amount as indicated in Table 11, of γ -glycidoxypyrpyltrimethoxysilane (silane comping compound) and the amount as indicated in Table 11, of DENACOL EX-421 (polyepoxide compound), dissolved in toluene. The coated cord was dried at a temperature of 100°C for 60 seconds and, then, heat treated at a temperature of 230°C for 120 seconds.

The surface-coated cord was impregnated in the same manner as that described in Example 43, dried at 100°C for 60 seconds and, then, heat treated at 230°C for 120 seconds.

In Comporative Example 23, the same procedures as those discribed in Example 50 were carried out, except that no silane comping compound used.

In Comparative Example 24, the same procedures as those described in Comparative Example 23 were carried out, except that the cord used was the same as that described in Comparative Example 17 in which no silicon dioxide fine particles were used.

In Comparative Example 25, the same procedures as those described in Example 50 were carried out, except that the cord used was the same as that described in Comparative Example 17.

The results of the tests are indicated in Table 11.

Table 11

Example No.	Type of cord	Surface coating composition (part by weight)		Heat resistance (°C)	CAR-bonding strength (kg/5C)			T-bonding strength (kg/cm)			Resistance to peeling (kg/3 cm)		
		Silane coupling compound	Polyepoxide compound		150°C 30 min	170°C 90 min	Vulcanization	150°C 30 min	170°C 90 min	Vulcanization	150°C 30 min	170°C 90 min	Vulcanization
23	Example 43	-	3	60	10.5	5.6	16.0	8.0	29	19.0			
24	Comparative Example 17	-	3	55	10.6	5.5	15.5	7.9	28	17.5			
50	Example 43	3	3	85	11.5	9.5	16.2	11.6	31	26.5			
51	"	5	3	85	11.8	9.9	16.3	11.8	30	25.5			
52	"	10	3	80	11.5	9.8	15.9	11.8	29	25.0			
25	Comparative Example 17	3	3	55	10.9	5.6	15.8	8.0	29	19.5			

Examples 53 through 64 and Comparative
Examples 26 through 28

In each of the Examples 53 through 64 and Comparative
Examples 26 through 28, a multifilament yarn having a yarn
5 count of 1670 dtex/250 filaments was prepared from an
amount, as indicated in Table 12, of silicon dioxide fine
particles having an average size as indicated in Table 12,
and a polyethylene terephthalate having an intrinsic
viscosity of 0.64 and a melting point of 260°C. The
10 multifilament yarn was converted into a cord having a yarn
count of 3340 dtex/500 filaments and composed of two
multifilament yarns each having a first twisting number of
40 turns/10 cm by ply twisting the two filament yarns
together at a ply twisting number of 40 turns/10 cm.

15 The cord was washed with methyl alcohol and, then,
dried at a temperature of 70°C for 180 seconds.

The cord was impregnated with a surface coating liquid
containing 3% by weight of an organic titanium compound as
indicated in Table 12. The impregnated cord was dried at a
20 temperature of 120°C for 120 seconds and, then, heat-treated
at a temperature of 150°C for 180 seconds. The heat-treated
cord contained 1.0% by dry weight of the titanium compound
based on the weight of the cord.

The surface coated cord was subjected to tests. The
25 results of the tests are indicated in Table 12.

Table 12

Example No.	Silicon dioxide fine particles		Organic titanium compound		Heat re- distance	CRA-bonding strength	T-bonding strength	Resistance to peeling
	Average size (μ)	Amount ($\%$ wt.)			($^{\circ}$)	(kg/5C)	(kg/cm)	(kg/3 cm)
Example	53	5	0.5	i-propyl-tri-i-stearoyl titanate	68	9.5	10.0	21.0
	54	10	"	"	70	10.0	13.1	20.0
	55	20	"	"	72	10.1	13.0	20.0
	56	50	"	"	73	10.2	14.8	21.0
	57	90	"	"	72	10.1	13.5	21.5
Comparative Example	26	10	0.2	"	60	10.0	10.5	18.0
Example	58	"	0.5	"	69	9.8	12.1	20.0
	59	"	1.0	"	70	10.1	12.1	20.0
	60	"	13.0	"	72	10.0	13.0	25.0
Comparative Example	27	"	16.0	"	65	10.5	12.8	20.0
Example	61	"	0.5	"	70	10.2	11.9	25.0
	62	"	"	Tetrastearyl titanate	70	10.1	12.1	21.0
	63	"	"	Tetrakis(2-ethylhexyl) titanate	69	9.8	12.2	21.5
	64	"	"	Tetra-n-butyl titanate	68	9.9	12.6	24.5
Comparative Example	28	-	0	i-propyl-tri-i-stearoyl titanate	52	2.1	4.5	10.5

Examples 65 through 72 and Comparative
Examples 29 through 36

In each of Examples 65, 67, 69 and 71, the same procedures as those described in Example 54 were carried out, except that the i-propyl-tri-i-stearoyl titanate was replaced by another titanium compound, as indicated in Table 13, the concentration of the titanium compound in the surface coating liquid was 5% by weight, the heat-treatment was carried out at 150°C for 120 seconds and the dry weight of the titanium compound picked up by the cord was 1.0% based on the weight of the cord.

In Examples 66, 68, 70 and 72, the same procedures as those described respectively in Examples 65, 67, 69 and 71 were carried out, except that before the tests, each surface-coated cord was pre-treated with a pre-treating liquid containing a resorcin-formaldehyde prepolymer, a vinylpyridine-styrene-butadiene terpolymer latex and diphenylmethane diethylene urea. The pre-treated cord was dried at 100°C for 120 seconds and, then, heat-treated at 230°C for 60 seconds.

In Comparative Examples 29, 31, 33 and 35, the same procedures as those respectively described in Examples 65, 67, 69 and 71 were carried out except that the cord used was the same as that used in Comparative Example 28 which contained no silicon dioxide fine particles.

In Comparative Examples 30, 32, 34 and 36, the same procedures as those respectively described in Examples 66, 68, 70 and 72 were carried out, except that the cord used was the same as that used in Comparative Example 28.

The results of the tests are indicated in Table 13.

Table 13

Example No.	Type of cord	Amount of silicon dioxide fine particles (% wt)	Organic titanium compound	Appli- cation of Pre- -treatment	CRA- -bonding strength (kg/5C)	T- -bonding strength (kg/cm)
Comparative Example 29	Comparative Example 28	0	1-propyl-tri-1-stearyl titanate	no	2.1	4.5
Example 65	Example 54	0.5	"	yes	6.0	10.5
Example 66	Example 54	0.5	"	no	10.0	13.1
			"	yes	11.6	16.5
Comparative Example 31	Comparative Example 28	0	Tetrastearyl titanate	no	2.0	3.5
Example 67	Example 54	0.5	"	yes	5.5	8.5
Example 68	Example 54	0.5	"	no	10.1	12.1
			"	yes	11.6	16.5
Comparative Example 33	Comparative Example 28	0	Tetrakis-(2-ethylhexyl) titanate	no	1.5	3.0
Example 69	Example 54	0.5	"	yes	4.0	7.5
Example 70	Example 54	0.5	"	no	9.8	12.2
			"	yes	12.0	16.2
Comparative Example 35	Comparative Example 28	0	Tetra-n-butyl titanate	no	2.0	3.5
Example 71	Example 54	0.5	"	yes	3.0	9.5
Example 72	Example 54	0.5	"	no	9.9	12.6
			"	yes	11.8	16.0

Examples 73 through 81 and Comparative
Examples 37 through 42

In each of the Examples 73 through 81 and Comparative
Examples 37 through 42, a core-in-sheath type composite
5 multifilament yarn having a yarn count of 1670 dtex/192
filaments was prepared from a sheath constituent comprising
an amount, as indicated in Table 14, of silicon dioxide
fine particles having an average size, as indicated in
Table 14, and the balance consisting of a polyethylene
10 terephthalate having an intrinsic viscosity of 0.64, and a
core constituent consisting of the same polyethylene
terephthalate as that mentioned above.

When the above-mentioned multifilament yarn was
prepared by the conventional melt-spinning process for
15 core-in-sheath type composite filaments, the filaments were
surface coated with a coating liquid having a type of
composition as indicated in Table 14. The type of
composition is shown in Table 9. During the drawing
procedure applied to the multifilament yarn, the yarn was
20 heat-treated at a temperature of 230°C for 60 seconds.

The surface coated multifilament yarn was converted
into a cord consisting of two multifilament yarns each
having a first twisting number of 40 turns/10 cm by ply
twisting them together at a ply twisting number of
25 40 turns/10 cm. The resultant cord had a yarn count of
about 3340 dtex/384 filaments.

The surface coated cord was pre-treated in the same
manner as that mentioned in Example 43, before the tests.
The tests were carried out in the same manner as mentioned
30 in Example 43.

The results are indicated in Table 14.

Table 14

Example No.	Silicon dioxide fine particles		Amount of sheath portion (wt.)	Type of Surface coating liquid	Tensile strength of cord (kg)	Heat resis- tance (%)	CRA-bonding strength (kg/5c)		T-bonding strength (kg/cm)		Resistance to peeling (kg/3 cm)	
	Average size (μ m)	Amount (wt. %)					Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min
Example 73	10	0.8	10	A	22.0	84	11.2	9.1	17.5	11.9	30	28
74	10	0.8	30	A	19.5	85	11.2	9.1	17.0	11.8	31	28
75	10	0.8	45	A	17.9	84	11.1	9.1	17.0	11.6	30	28
76	10	0.8	20	B	20.5	84	11.5	9.3	17.4	11.8	30	28
77	10	0.8	20	C	20.5	85	11.2	9.0	17.3	11.8	30	27
Comparative Example 37	10	0.8	20	D	20.5	66	10.9	5.6	16.9	7.6	29	18
38	10	0.8	20	E	20.4	64	10.8	5.8	16.0	8.0	28	18.5
39	10	0.8	20	F	20.5	65	10.9	5.6	16.3	7.5	29	18
Example 78	10	13.0	20	A	20.4	85	11.5	9.2	17.4	11.6	30	27.5
Comparative Example 40	10	16.0	20	A	20.4	75	10.5	5.5	17.0	7.8	30	16.5
Example 79	5	0.8	20	A	20.5	85	11.5	9.0	17.5	9.0	30	27.0
80	50	0.8	20	A	20.4	84	11.6	9.0	17.4	8.9	31	28.0
81	90	0.8	20	A	20.4	85	11.7	9.2	17.5	8.8	30	27.0
Comparative Example 41	110	0.8	20				Failed to melt-spin					
42	0	0	0	A	22.5	65	8.5	3.2	12.1	6.0	31	19

Examples 82 through 84 and Comparative
Examples 43 through 45

In each of the Examples 82 through 84, the same procedures as those described in Example 78 were carried
5 out, except that a surface coating liquid containing 3% by dry weight of compounds indicated in Table 15 and the balance toluene was applied to the cord, the surface coated cord was dried at 100°C for 60 seconds and, then, heat
10 treated at 230°C for 120 seconds. Then, the surface coated cord was pre-treated by the same procedures as those described in Example 43, before the tests.

In Comparative Example 43, the same procedures as those described in Example 82 were carried out, except that
15 no silane coupling compound was used.

In Comparative Example 44, the same procedures as those described in Comparative Example 43 were carried out,
20 except that the cord used was the same as described in Comparative Example 42 which cord contained no silicon dioxide fine particles.

In Comparative Example 45, the same procedures as those described in Example 82 were carried out, except that
the cord used was the same as that used in Comparative Example 42.

The results of the tests are indicated in Table 15.

Table 15

Example No.	Type of cord	Composition of surface coating liquid (part by weight)		Tensile strength of cord (kg)	Heat resistance (%)	CRA-bonding strength (kg/5c)		T-bonding strength (kg/cm)		Resistance to peeling (kg/3 cm)	
		Silane coupling compound (*)1	Poly-epoxide compound (*)2			Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min
Comparative Example 43	Example 78	-	3	20.4	60	10.5	5.6	16.0	8.0	29	19.0
44	Comparative Example 42	-	3	22.5	55	10.6	5.5	15.5	7.9	28	17.5
82		3	3	20.3	85	11.5	9.5	18.2	11.8	31	26.5
Example 83	Example 78	5	3	20.3	85	11.8	9.8	17.8	12.0	30	25.5
84		10	3	20.5	80	11.5	9.8	17.9	11.9	29	25.0
Comparative Example 45	Comparative Example 42	3	3	22.6	55	10.9	5.6	15.8	8.0	29	19.5

Notes: (*)1 -glycidioxypropyltrimethoxysilane
 (*)2 DENACOL EX - 421

Examples 85 through 88 and Comparative
Examples 46 and 47

In each of the Examples 85 through 88 and Comparative Examples 46 and 47, a multifilament yarn having a yarn
5 count of 1670 dtex/192 filaments was prepared from an amount, as indicated in Table 16, of silicon dioxide fine particles having an average size as indicated in Table 16, and the balance consisting of a polyethylene terephthalate having an intrinsic viscosity of 0.64. The multifilament
10 yarn was converted into the same cord as that described in Example 43.

The cord was impregnated with a surface coating liquid containing 5% by weight of γ -glycidoxypyrpyltrimethoxysilane dissolved in water. The impregnated cord was dried at
15 230°C for 60 seconds and, then, heat treated at 120°C for 120 seconds. The amount of the silane coupling compound picked up by the cord was 0.8% by dry weight based on the weight of the cord.

Before being subjected to the tests, the surface
20 coated cord was pre-treated in the following manner.

A first pre-treating liquid was prepared in such a manner that a uniform solution of 6 g of DENACOL EX-611 in 4 g of NEOCOL SW-30 was added into 805 g of water while vigorously stirring the mixture to provide an aqueous
25 solution of DENACOL EX-611, and, the solution was mixed with a 14 g of Hylene MP with 40 g of NEOCOL SW-30 and 42 g of water which were mixed in a ball mill for 24 hours. The resultant composition was used as the first pre-treating liquid.

30 The surface coated cord was impregnated with the first pre-treating liquid, dried at 150°C for 2 minutes and, then, heat-treated at 230°C for one minute. The dry weight of the first pre-treating material picked up by the cord was 2.2% based on the weight of the cord.

35 A second pre-treating liquid was prepared in such a manner that an aqueous solution consisting of 10 g of a 10% sodium hydroxide aqueous solution, 30 g of a 28% ammonia

aqueous solution and 260 g of water, were mixed with 60 g of a 40% acetone solution of a resorcin-formaldehyde prepolymer which was prepared by using an acid catalyst, to provide an aqueous dispersion, and the prepolymer

- 5 dispersion was slowly added into an aqueous liquid prepared by mixing 240 g of NIPPOL 2518FS and 100 g of NIPPOL LX-112 into 200 g of water, and, finally, 20 g of a 37% aqueous solution of form aldehyde were further mixed into the above mixture.

- 10 The resultant mixture was slowly mixed with 162 g of a 70% aqueous solution of sulfur-modified resorcin which was available under the trademark of SUMIKANOL 750 from SUMITOMO KAGAKU KOGYO CO., JAPAN. The resultant mixture was further mixed with 20 g of diphenylmethane diethylene
15 area, 7 g of NEOCOL SW-30 and 53 g of water. The mixture was stirred by using a ball mill for 24 hours. The resultant mixture was used as the second pre-treating liquid.

- The first pre-treated cord was further pre-treated
20 with the second pre-treating liquid, dried at 150°C for 2 minutes and, then, heat-treated at 230°C for one minute. The dry weight of the second pre-treating material picked up by the cord was 2.5% based on the weight of the cord.

- 25 The results of the tests are indicated in Table 16.

Table 16

Example No.	Silicon dioxide fine particles		Application or surface coating material	Heat resistance (%)	CRA-bonding strength (kg/5c)		T-bonding strength (kg/cm)		Resistance to peeling (kg/3 cm)		Rubber coverage (%)		Resistance to bending (mg)
	Average size (nm)	Amount (g wt)			Vulcanization	150°C 30 min	Vulcanization	150°C 30 min	Vulcanization	150°C 30 min	Vulcanization	150°C 30 min	
Example 85	10	0.8	yes	85	12.9	8.0	17.0	12.0	32	27	90	75	2500
Comparative Example 46	10	0.8	no	85	6.5	4.5	11.0	7.0	16	10	50	40	3500
Example 86	90	0.8	yes	80	12.5	8.5	16.5	12.0	32	24	85	70	2000
	10	13	yes	85	13.0	8.5	17.5	12.5	32	27	90	75	2200
Comparative Example 47	10	16	yes	70	9.5	7.0	13.0	10.0	18	15	55	25	3500
Example 88	5	0.8	yes	80	12.5	8.5	17.0	12.5	32	29	90	75	2100

Examples 89 through 92

In each of the Examples 89 through 92, the same procedures as those described in Example 85 were carried out, except that the γ -glycidoxypropyltrimethoxysilane was replaced by the type of silane coupling compound as indicated in Table 17.

The results are indicated in Table 17.

Table 17

Example No.	Silane coupling compound	Heat resistance (%)	CRA-bonding strength (kg/5C)		γ -bonding strength (kg/cm)		Resistance to peeling (kg/3 cm)		Rubber coverage		Resistance to bending (mg)
			Vulcanization	170°C 90 min	Vulcanization	150°C 30 min	Vulcanization	150°C 30 min	Vulcanization	170°C 90 min	
89	Vinyl trichlorosilane	80	12.0	9.5	16.5	13.0	31	27	80	65	2500
90	N- β (aminocethyl)- γ -aminopropyl-trimethoxysilane	70	11.5	9.0	16.0	12.5	28	26	80	65	2900
91	γ -mercaptoethyltrimethoxysilane	85	12.5	9.5	17.0	13.5	30	26	85	70	2100
92	Vinyl ethoxysilane	80	12.0	9.0	16.5	13.0	31	27	90	70	2200

Examples 93, 94 and 95

In Example 93, the same procedures as those described in Example 85 were carried out, except that the DENACOL EX-611 was replaced by the polyepoxide compound indicated in Table 18.

In each of Examples 94 and 95, the same procedures as those described in Example 85 were carried out, except that the Hylene MP was replaced by the blocked polyisocyanate compound as indicated in Table 18.

The results are shown in Table 18.

Table 18

Example No.	Compound in first pre-treating material	Heat resistance (%)	CRA-bonding strength (kg/5C)			T-bonding strength (kg/cm)			Resistance to peeling (kg/3cm)			Rubber coverage			Resistance to bending (mg)
			Vulcanization 130°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	
93	Polyepoxide: pentaerythritol diglycidyl ether	85	12.5	10.0	17.5	13.5	32	28	85	50					2600
94	Blocked polyisocyanate: 4,4'-diiphenylmethane diisocyanate-ε-caprolactam-blocking product	80	12.0	9.5	17.0	12.5	30	27	90	65					2500
95	Polymethylene polyphenyl-isocyanate-phenol-blocking product	85	12.5	9.5	17.5	13.0	31	20	85	65					2300

Examples 96, 97 and 98

In each of the Examples 96, 97 and 98, the same procedures as those described in Example 85 were carried out, except that the diphenylmethane diethylene urea in the
5 second pre-treating material was replaced by the compound as indicated in Table 19.

The results are also indicated in Table 19.

Table 19

Example No.	Ethylene urea compound	Heat resistance (%)	CRA-bonding strength (kg/5C)			T-bonding strength (kg/cm)			Resistance to peeling (kg/3cm)			Rubber coverage			Resistance to bending (mg)
			Vulcanization	150°C	170°C	Vulcanization	150°C	170°C	Vulcanization	150°C	170°C	30 min	150°C	170°C	
96	Toluenediethylene urea	85	12.5	9.5	16.5	13.5	31	27	90	70	2200				
97	Hexamethylene diethylene urea	80	12.0	10.0	17.0	14.0	31	27	90	75	2300				
98	Triphenylmethane triethylene urea	80	12.5	10.5	16.0	13.5	32	26	90	70	2100				

Examples 99 through 102

In each of the Examples 99 through 102, the same procedures as those described in Example 85 were carried out, except that a mixture of one part by weight of the surface coating liquid and one part by weight of the first pre-treating liquid was used as the surface coating liquid, the first pre-treating procedures were omitted and the cord used in Example 99 was the same as that used in Example 85, the cord used in Example 100 was the same as, that used in Example 86, the cord used in Example 101 was the same as that used in Example 87 and the cord used in Example 102 was the same as that used in Example 88.

The results are shown in Table 20.

Table 20

Example No.	Type of cord used	Heat resistance (%)	CMA-bonding strength (kg/5C)		T-bonding strength (kg/cm)		Resistance to peeling (kg/3cm)		Rubber coverage		Resistance to bending (mg)
			Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	
99	Example 85	85	12.5	10.0	17.5	13.5	31	20	90	70	2100
100	Example 86	80	12.0	9.5	17.0	13.0	29	26	85	65	2500
101	Example 87	85	12.5	10.0	16.5	12.5	30	27	90	65	2200
102	Example 88	80	12.0	9.5	17.0	13.5	30	27	90	70	2400

Examples 103 through 106 and Comparative
Examples 48 and 49

In each of the Examples 103 through 106 and Comparative Examples 48 and 49, the same cord as that
5 described in Example 85 was surface coated with a surface coating liquid containing a surface coating material consisting of 2.5 g of γ -glycidoxypyrpyltrimethoxysilane and 2.5 g of sorbitol polyglycidylether which was available under a trademark of DENACOL EX-111 from NAGASE SANGYO CO.,
10 JAPAN, dissolved in 95 g of water, by using a tire cord treating machine.

The surface treated cord was dried at 150°C for 2 minutes and, then, heat-treated at 230°C for one minute. The dry weight of the surface coating material picked up by
15 the cord was 2.2% based on the weight of the cord.

The surface coated cord was pre-treated, before being subjected to the tests, with the following pre-treating liquid.

60 g of a 40% acetone solution of a resorcin-
20 -formaldehyde prepolymer which was prepared in the presence of an acid catalyst, were dispersed in an aqueous solution which was a mixture of 10 g of a 10% aqueous solution of sodium hydroxide, 30 g of a 28% aqueous solution of ammonia and 260 g of water, while stirring the aqueous dispersion.

25 A dispersion was prepared by mixing 14 g of HYLENE MP and 42 g of water in a ball mill for 24 hours. This dispersion was uniformly mixed with the above-mentioned aqueous dispersion, to provide an aqueous dispersion mixture. Separately, an aqueous emulsion was prepared
30 mixing 100 g of NIPPOL 2518 FS and 100 g NIPPOL LX-112 with 200 g of water.

The above-mentioned aqueous dispersion mixture was mixed with the aqueous emulsion while slowly stirring the mixture and, then, 20 g of a 37% aqueous solution of
35 formaldehyde were mixed into the mixture.

This mixture was further mixed with 162 g of a 70% aqueous solution of a sulfur-modified resorcin-formaldehyde

prepolymer, which was available under the trademark of SUMIKANOL 750 from SUMITOMO KAGAKU KOGYO CO., JAPAN, while slowly stirring the resultant mixture, and, then, with a dispersion which was prepared by mixing 20 g of diphenyl-
5 methane diethylene urea, 7 g of NEOCOL SW-30 and 53 g of water in a ball mill for 24 hours. The resultant mixture was used as a pre-treating liquid.

The surface-coated cord was pre-treated with the pre-treating liquid, dried at 150°C for 2 minutes. The dry
10 weight of the pre-treating material picked up by the cord was 2.5% based on the weight of the cord.

The pre-treated cord was subjected to the tests for the items as indicated in Table 21. The results of the tests are also indicated in Table 21.

Table 21

Example No.	Silicon dioxide fine particles		Heat resistance (%)	CRA-bonding strength (kg/5c)		T-bonding strength (kg/cm)		Resistance to peeling (kg/3cm)		Rubber coverage (%)		Resistance to bending (mg)
	Average size (μm)	Amount (% wt)		Vulcanization	150°C 30 min	Vulcanization	150°C 30 min	Vulcanization	150°C 30 min	Vulcanization	150°C 30 min	
Example 103	10	0.8	85	12.9	9.0	17.0	12.5	32	7	90	75	2500
Comparative Example												
48	10	0.8	60	8.0	6.5	13.0	9.0	18	5	50	25	1800
Example												
104	90	0.8	80	12.6	9.2	17.2	12.1	31	6	85	70	2000
105	10	13	80	12.2	9.3	17.1	12.3	30	6	85	70	2100
Comparative Example												
49	10	16	70	10.9	7.6	16.0	10.0	27	2	80	65	3500
Example												
106	5	0.8	85	12.3	9.0	17.2	12.5	31	7	85	70	2200

Examples 107 through 110

In each of the Examples 107 through 110, the same procedures as those described in Example 103 were carried out, except that the γ -glycidoxypyrpyltrimethoxysilane was
5 replaced by the silane coupling compound as indicated in Table 22.

The results of the tests are indicated in Table 22.

Table 22

Example No.	Silane coupling compound	Heat resistance (s)	CRA-bonding strength (kg/5C)		T-bonding strength (kg/cm)		Resistance to peeling (kg/1cm)		Rubber coverage		Resistance to bending (mg)
			Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	
107	Vinyl trichlorosilane	80	12.0	9.5	16.5	13.0	31	27	80	65	2500
108	N-β(aminoethyl)-γ-aminopropyl-trimethoxysilane	70	11.5	9.0	16.0	12.5	28	26	80	65	2900
109	γ-mercaptopropyltrimethoxysilane	85	12.5	9.5	17.0	13.5	30	26	85	70	2100
110	Vinyl thoxysilane	80	12.0	9.0	16.5	13.0	31	27	90	70	2200

Examples 111 through 119 and Comparative
Examples 50 through 54

In each of the Examples 111 through 119 and Comparative Examples 50 through 54, the same procedures as those
5 described in Example 73 were carried out with the following exception.

1. In each example or comparative example, the type of the surface coating material used was the one indicated in Table 23. Each type of the surface coating material had
10 the composition as indicated in Table 9.

2. The cord which was prepared from surface coated core-in-sheath type multifilament yarns, was pre-treated, before being subjected to the tests, with the following pre-treating liquid.

15 A resorcin-formaldehyde prepolymer was prepared by reacting 22 g of resorcin with 29 g of a 37% aqueous solution of formaldehyde in the presence of 31 g of a 28% aqueous solution of ammonia and 500 g of water, at a temperature of 25°C while stirring the reaction mixture for
20 3 hours. The reaction mixture was further mixed with 418 g of NIPPOL 2518 FS at a temperature of 25°C by stirring the mixture for 48 hours. The resultant RFL liquid was mixed with 162 g of SUMIKANOL 750 (Sulfur-modified) resorcin. The resultant mixture was used as the pre-treating liquid.

25 The surface coated cord was pretreated with the pre-treating liquid, dried at a temperature of 100°C for 60 seconds and heat-treated at a temperature of 230°C for 120 seconds.

The resultant pre-treated cord was subjected to the
30 tests. The results of the tests are indicated in Table 23.

Table 23

Example No.	Silicon dioxide fine particles		Amount of sheath portion (g wt.)	Type of surface coating liquid (*)1	Tensile strength of cord (kg)	Heat resistance (%)	CRA-bonding strength (kg/5C)			T-bonding strength (kg/cm)			Resistance to peeling (kg/3cm)					
	Average size (μm)	Amount (g wt.)					150°C	170°C	30 min	90 min	150°C	170°C	30 min	90 min	150°C	170°C	30 min	90 min
Example	111	10	0.8	10	A	22.0	84	12.5	10.1	17.5	12.2	30	28					
	112	10	0.8	30	A	19.5	85	13.0	10.5	18.5	12.1	31	28					
	113	10	0.8	45	A	17.9	84	10.8	8.6	17.5	11.6	30	28					
	114	10	0.8	20	B	20.5	85	12.5	10.1	18.0	12.0	30	28					
	115	10	0.8	20	C	20.5	86	12.6	10.1	18.0	12.1	30	27					
Comparative Example	50	10	0.8	20	D	20.4	65	10.9	5.8	17.0	8.0	29	17					
	51	10	0.8	20	E	20.5	65	10.8	5.9	17.2	7.5	28	19					
	52	10	0.8	20	F	20.5	65	10.9	6.0	16.5	8.0	29	18.5					
Example	116	10	13.0	20	A	20.5	85	12.8	10.4	17.9	10.9	30	27					
Comparative Example	53	10	16.0	20	A	20.5	75	10.8	5.6	17.0	9.9	30	16					
Example	117	5	0.8	20	A	20.5	85	12.5	9.9	17.5	11.2	31	26					
	118	50	0.8	20	A	20.4	84	12.1	9.8	18.0	11.9	30	28					
	119	90	0.8	20	A	20.4	85	12.3	9.8	17.6	11.6	30	27					
Comparative Example	54	-	0	0	A	22.5	70	8.5	3.2	12.1	6.0	31	19					

Examples 120 through 122 and Comparative
Examples 55 through 57

In Example 120, the same procedures as those described in Example 116 were carried out, except that the surface
5 coating liquid contained a surface coating material consisting of 3% by weight of γ -glycidoxypropyltrimethoxy-silane (silane coupling compound) and 3% by weight of DENACOL EX-421 (Polyepoxide compound), and dissolved in toluene, that the surface coating liquid was applied to the
10 cord which was prepared from the core-in-sheath type multifilament yarns oiled with a usual oiling agent, that the surface coated cord was dried at 100°C for 60 seconds and, then, heat-treated at 230°C for 120 seconds, and the dry weight of the surface coating material picked up by the
15 cord was 0.8% based on the weight of the cord.

In each of the Examples 121 and 122, the same procedures as those described in Example 120 were carried out, except that the silane coupling compound and the polyepoxide compound were used in amounts as indicated in
20 Table 24.

In Comparative Example 55, the same procedures as those described in Example 120 were carried out except that no silane coupling compound was used.

In Comparative Example 56, the same procedures as
25 those described in Comparative Example 55 were carried out, except that the cord used was the same as that used in Comparative Example 54.

In Comparative Example 57, the same procedures as those described in Example 120 were carried out, except
30 that the cord used was the same as that used in Comparative Example 54.

The results of the tests are indicated in Table 24.

Table 24

Example No.	Type cord	Surface coating material		Tensile strength of cord (kg)	Heat resistance (%)	CMA-bonding strength (kg/5C)	T-bonding strength (kg/cm)			Resistance to peeling (kg/3cm)		
		Silane coupling compound (% by wt)	polyepoxide compound (% by wt)				Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min	Vulcanization 150°C 30 min	Vulcanization 170°C 90 min
Comparative Example 55	Example 116	-	3	20.4	65	10.5	6.5	16.0	8.5	29	19	
Comparative Example 56	Comparative Example 54	-	3	22.5	60	10.8	5.8	16.0	8.4	28	18	
Example 120	Example 116	3	3	20.3	85	12.5	10.0	19.0	12.5	31	27	
	Example 116	5	3	20.3	88	12.4	9.8	18.5	13.5	30	26.5	
	Example 116	10	3	20.5	85	12.2	10.1	18.3	12.2	29	25	
Comparative Example 57	Comparative Example 54	3	3	22.6	60	11.8	6.1	16.0	8.4	29	19.5	

Examples 123 through 129 and Comparative
Examples 58 through 62

In each of the Examples 123 through 129 and Comparative
Examples 58 through 62, the same procedures as those
5 described in Example 43 were carried out with the following
exception.

1. In each example or comparative example, the
average size and amount of the silicon dioxide fine
particles were those as indicated in Table 25, and the type
10 of the surface coating material applied onto the melt-spun
multifilament yarn was as indicated in Table 25. The
composition of each surface coating material is indicated
in Table 9.

2. The cord prepared from the surface coated
15 multifilament yarns was pre-treated, before being subjected
to the tests, with the following pre-treating liquid.

In order to prepare the pre-treating liquid, 22 g of
resorcin, 29 g of a 37% aqueous solution of formaldehyde,
31 g of a 28% aqueous solution of ammonia and 500 g of
20 water were mixed altogether, the mixture was stirred at a
temperature of 25°C for 3 hours to provide a resorcin-
-formaldehyde prepolymer solution, the resultant prepolymer
solution was mixed with 418 g of NIPPOL 2518FS, the mixture
was stirred at 25°C for 48 hours to provide an RFL
25 emulsion, and the emulsion was mixed with 162 g of
SUMIKANOL 750.

The cord was pre-treated with the pre-treating liquid,
dried at 100°C for 60 seconds and, then, heat-treated at
230°C for 120 seconds. The dry weight of the pre-treating
30 material picked up by the cord was 6.0% based on the weight
of the cord.

The results of the tests are indicated in Table 25.-

Table 25

Example No.	Silicon dioxide fine particle		Type of surface coating material (*)	Heat resistance (%)	CRA-bonding strength (kg/5c)		T-bonding strength (kg/cm)		Resistance to peeling (kg/3cm)	
	Average size (μ)	Amount (%wt.)			Vulcani- zation 150°C 30min	170°C 90min	Vulcani- zation 150°C 30min	170°C 90min	Vulcani- zation 150°C 30min	170°C 90min
Example 123	10	0.8	A	85	12.5	10.5	10.5	13.5	32	29
124	10	0.8	B	80	12.4	10.4	10.4	13.0	31	29
125	10	0.8	C	85	12.6	10.1	19.0	13.5	30	27
Comparative Example 58	10	0.8	D	70	11.1	6.5	17.0	8.0	30	19
59	10	0.8	E	70	11.2	6.2	16.8	7.9	29	20.5
60	10	0.8	F	70	11.5	6.5	16.5	8.2	28	19
Example 126	10	13.0	A	85	12.0	10.2	18.6	12.5	31	28
Comparative Example 61	10	16.0	A	80	10.5	5.2	16.0	8.0	28	15.5
Example 127	5	0.8	A	85	12.0	10.2	18.6	12.5	30	28
128	50	0.8	A	85	12.2	9.9	18.5	13.0	31	29
129	90	0.8	A	85	12.0	10.5	18.0	12.4	32	28
Comparative Example 62	-	0	A	65	8.0	3.2	12.1	6.0	31	19

Note: (*)-Refer to Table 9

Examples 130 through 132 and Comparative
Examples 63 through 65

In Example 130, the same procedures as those described in Example 123 were carried out, except that the surface coating liquid was a solution of a surface coating material consisting of 3% by weight of γ -glycidoxypropyltrimethoxysilane (silane coupling compound) and 3% by weight of DENACOL EX-421 (polyepoxide compound) in toluene, that the surface coating liquid was applied to the cord prepared from the melt-spun multifilament yarns which were oiled with a usual oiling agent, and that the surface coated cord was dried at 100°C for 60 seconds, and heat-treated at 230°C for 120 seconds.

In Examples 131 and 132, the same procedures as those described in Example 130 were carried out, except that the surface coating liquid contained the silane coupling compound and the polyepoxide compound in amounts as indicated in Table 26.

In Comparative Example 63, the same procedures as those described in Example 130 were carried out, except that no silane coupling compound was contained in the surface coating liquid.

In Comparative Example 64, the same procedures as those described in Comparative Example 63 were carried out, except that the cord used was the same as that used in Comparative Example 62.

In Comparative Example 65, the same procedures as those described in Example 130 were carried out, except that the cord used was the same as that used in Comparative Example 62.

The results are indicated in Table 26.

Table 26

Example No.	Type of cord	Silicon dioxide fine particles		Heat resistance (%)	CRA-bonding strength (kg/5c)	η -bonding strength (kg/5cm)	Resistance to peeling (kg/3cm)
		Silane coupling compound	Polyepoxide compound				
		(% by wt.)	(% by wt.)		Vulcanization 150°C 30min	Vulcanization 170°C 90min	Vulcanization 150°C 30min 170°C 90min
Comparative Example 63	Example 123	-	3	60	10.5	16.0	29 19.0
64	Comparative Example 62	-	3	55	10.7	16.4	28 17.5
Example 130	Example 123	3	3	85	12.5	18.4	32 28.0
131	"	5	3	85	12.6	18.5	31 29.0
132	"	10	3	80	12.5	18.4	31 26.5
Comparative Example 65	Comparative Example 62	3	3	55	10.8	15.8	28 19.5

Examples 133 through 136 and Comparative
Examples 66 and 67

In Example 133, the same procedures as those described in Example 103 were carried out, except that in the
5 preparation of the pre-treating liquid, the addition of SUMIKANOL 750 was omitted.

In Examples 134, 135 and 136, the same procedures as those described repectively in Examples 104, 105 and 106,
were carried out, except that the pre-treating liquid used
10 was the same as that described in Example 133.

In Comparative Examples 66 and 67, the same procedures as those described repectively in Comparative Examples 48 and 49, were carried out, except that the pre-treating
liquid used was the same as that used in Example 133.

15 The results of the test are shown in Table 27.

Table 27

Example No.	Silicon dioxide fine particle		Surface coating material		Heat resis- tance	CPA-bonding strength (kg/5c)		T-bonding strength (kg/cm)		Resistance to peeling (kg/3cm)		Rubber coverage		Resistance to bending
	Average size	Amount	Silane coupling compound	Poly- epoxide compound	(%)	(g)	(g)	(kg/5c)	(kg/cm)	(kg/3cm)	(kg/3cm)	(%)	(%)	(mg)
Example 133	10	0.8	2.5	2.5	80	12.9	7.5	17.0	11.5	32	23	90	75	2500
Comparative Example 66	10	0.8	-	2.5	60	8.0	5.5	13.0	9.0	18	15	50	25	1800
Example 134	90	0.8	2.5	2.5	75	12.6	7.4	17.2	11.8	31	24	85	70	2000
135	10	13	2.5	2.5	75	12.2	7.0	17.1	11.5	30	23	85	70	2100
Comparative Example 67	10	16	2.5	2.5	65	10.9	6.0	16.0	9.5	27	20	80	65	3500
Example 136	5	0.8	2.5	2.5	75	12.3	7.3	17.2	11.5	31	23	85	70	2200

Examples 137 through 140

In each of the Examples 137 through 140, the same procedruess as those described in Example 133 were carried out, except that the silane coupling compound used was as
5 indicated in Table 28. The results of the tests are also indicated in Table 28.

Table 28

Example No.	Silane coupling compound	Heat resistance (%)	CRA-bonding strength (kg/5c)		T-bonding strength (kg/cm)		Resistance to peeling (kg/3cm)		Rubber coverage		Resistance to bending (mg)
			Vulcani- zation	150°C 30min	Vulcani- zation	150°C 30min	Vulcani- zation	150°C 30min	Vulcani- zation	150°C 30min	
137	Vinyl trichlorosilane	75	12.0	7.8	16.5	10.5	31	24	80	65	2500
138	N-β(aminoethyl)-γ-amino-propyltrimethoxysilane	60	11.5	7.5	16.0	10.4	28	22	80	60	2900
139	γ-mercaptopropyl-trimethoxysilane	80	12.3	7.5	17.0	10.5	30	23	85	65	2100
140	Vinyl ethoxysilane	75	12.0	7.0	16.5	10.7	31	24	85	65	2200

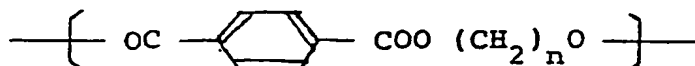
CLAIMS

1. A shaped polyester composite material having an activated surface thereof, comprising:

a shaped substrate comprising a polymeric matrix consisting essentially of an aromatic linear polyester and fine solid particles each comprising mainly silicon dioxide and having an average size of 5 to 100 millmicrons, said silicon dioxide fine particles being dispersed in at least a portion of said polyester matrix located in a surface portion of said shaped substrate and the amount of said fine particles being in the range of 0.3 to 15% based on the weight of said polyester matrix in which said fine particles are dispersed, and;

a surface coating layer formed on the silicon dioxide fine particle-containing surface portion of said shaped substrate whierein said silicon dioxide fine particles are located, and comprising a surface-activating material consisting of at least one member selected from the group consisting of silane coupling compounds and organic titanium compounds, said surface coating layer having been heat-treated together with said shaped substrate at a temperature of 50°C or more but at least 10°C below the melting point of said polyester matrix.

2. A shaped polyester composite material as claimed in claim 1, wherein said aromatic linear polyester has at least 85% by molar amount of securring units of the formula (I):



wherein n represents an integer of 2 to 6.

3. A shaped polyester composite material as claimed in claim 1, wherein the average size of said silicon dioxide fine particles is in the range of from 7 to 50 microns.

4. A shaped polyester composite material as claimed in claim 1, wherein the amount of said silicon dioxide fine

particles is in the range of from 0.5 to 10% by weight.

5. A shaped polyester composite material as claimed in claim 1, wherein said fine particles comprise at least 80% by weight of silicon dioxide (SiO_2).

5 6. A shaped polyester composite material as claimed in claim 1, wherein said fine particles comprise mainly amorphous silicon dioxide.

7. A shaped polyester composite material as claimed in claim 1, wherein said silicon dioxide fine particles are
10 uniformly distributed throughly in said polyester matrix in said shaped substrate.

8. A shaped polyester composite material as claimed in claim 1, wherein said silicon dioxide fine particles are distributed only in a portion of said polyester matrix
15 located in the surface portion of said shaped substrate.

9. A shaped polyester composite material as claimed in claim 1, wherein said shaped substrate is a filament or fiber.

10. A shaped polyester composite material as claimed
20 in claim 9, wherein said filament or fiber substrate is composed of a core portion thereof comprising an aromatic linear polyester alone, and a sheath portion thereof formed around said core portion and comprising said polyester matrix and said silicon dioxide fine particles.

25 11. A shaped polyester composite material as claimed in claim 10, wherein the weight of said sheath portion is 5% or more based on the entire weight of said filament or fiber substrate.

12. A shaped polyester composite material as claimed
30 in claim 10, wherein said aromatic linear polyester in said core portion exhibits an intrinsic viscosity of 0.6 or more.

13. A shaped polyester composite material as claimed in claim 1, wherein said shaped substrate is a film or
35 sheet.

14. A shaped polyester composite material, as claimed in claim 1, wherein the amount of said surface activating

material is in the range of from 0.5 to 10% based on the weight of said shaped substrate.

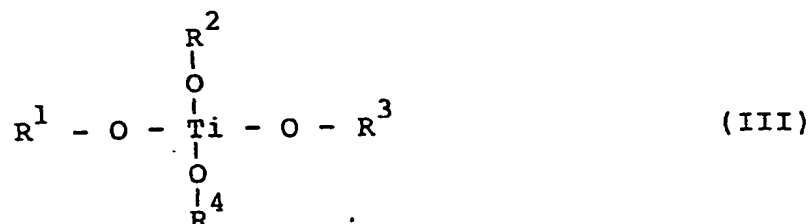
15. A shaped polyester composite material as claimed in claim 1, wherein said silane coupling compounds are of the formula (II):



wherein R represents a member selected from the group consisting of vinyl, methacryl, allyl, epoxy, hydroxyl, amino and mercapto radicals and organic and inorganic functional radicals each having at least one chlorine atom, and; X represents a member selected from the group consisting of organic and inorganic groups capable of reacting with siloxane radical and/or silanol radicals.

16. A shaped polyester composite material as claimed in claim 1, wherein said silane coupling compound is selected from the group consisting of vinyl trichlorosilane, vinyl triethoxysilane, vinyl trimethoxysilane vinyl-tris(β -methoxyethoxy)silane, γ -methacryloxypropyl-trimethoxysilane, γ -methacryloxypropyl-tris(β -methoxyethoxy)silane, β -(3,4-epoxycyclohexyl)ethyltrimethoxysilane, γ -glycidoxypropyltrimethoxysilane, vinyl triacetoxysilane, γ -mercaptopropyltrimethoxysilane, γ -aminopropyltriethoxysilane, N- β (aminoethyl)- γ -aminopropyltrimethoxysilane, bis(β -hydroxyethyl)- γ -aminopropyltrimethoxysilane, γ -chloropropyltrimethoxysilane, N-(trimethoxysilylpropyl)diethylenetriamine, N-(trimethoxysilylpropyl)urea, carboethoxyethylaminopropyltriethoxysilane, chloromethylphenyltrimethoxysilane, phenylaminopropyltrimethoxysilane, aminophenyltrimethoxysilane, and N-(dimethoxymethylsilylpropyl)ethylenediamine.

17. A shaped polyester composite material as claimed in claim 1, wherein said organic titanium compounds are of the formula (III):



5

wherein R^1 , R^2 , R^3 and R^4 respectively represents, independently from each other, a member selected from the group consisting of alkyl, alkenyl and acyl radicals each
 10 having 2 to 24 carbon atoms.

18. A shaped polyester composite material as claimed in claim 1, wherein said organic titanium compound is selected from the group consisting of tetra-n-butyltitanate, tetrakis(2-ethylhexyl)titanate, tetrastearyltitanate,
 15 iso-propyl-tri-iso-stearoyltitanate and iso-propyl-iso-stearoyl-dimethacroyltitanate.

19. A shaped polyester composite material as claimed in claim 1, wherein said surface coating layer contains an additional material comprising at least one polyepoxide
 20 compound, in addition to said surface activating material, said additional material having been heat-treated.

20. A shaped polyester composite material as claimed in claim 19, wherein said polyepoxide compound contains at least two epoxy groups per molecule thereof.

21. A polyester fiber composite material as claimed in claim 19, wherein said polyepoxide compound is selected from the group consisting of reaction products of polyhydric alcohols with halogenated epoxide compounds, reaction
 25 products of polyhydric phenol compounds with halogenated epoxide compounds and oxidation products of unsaturated organic compounds having at least one aliphatic double bond with peracetic acid or hydrogen peroxide.

22. A shaped polyester composite material as claimed in claim 19, wherein said polyepoxide compound is selected
 35 from polyglycidyl ethers of polyhydric alcohols, which are reaction products of epichlorohydrin with polyhydric alcohols.

23. A shaped polyester composite material as claimed in claim 21 or 22, wherein said polyhydric alcohol is selected from the group consisting of ethylene glycol, glycerol, diglycerol, diethylene glycol, sorbitol, pentaerythritol trimethylol propane, polyethylene glycols and polypropylene glycols.

24. A shaped polyester composite material as claimed in claim 21, wherein said halogenated epoxide compound is epichlorohydrin.

10 25. A shaped polyester composite material as claimed in claim 21, wherein said polyhydric phenol compound is selected from the group consisting of resorcin, catechol, 2,2-bis(4-hydroxyphenyl)propane, bis(4-hydroxyphenyl)dimethyl methane, phenol-formaldehyde resins and resorcin-formaldehyde
15 resins.

26. A shaped polyester composite material as claimed in claim 21, wherein said oxidation product is selected from the group consisting of 4-vinyl cyclohexene dioxide, 3,4-epoxycyclohexylmethyl-3,4-epoxycyclohexene carboxylate
20 and bis(3,4-epoxy-6-methylcyclohexylmethyl)adipate.

27. A shaped polyester composite material as claimed in claim 19, wherein said additional material is in an amount of 0.05 to 2% based on the weight of said shaped substrate.

25 28. A shaped polyester composite material as claimed in claim 19, wherein said surface coating layer contains, in addition to said surface activating material and said additional material, a further additional material comprising at least one blocked polyisocyanate compound of
30 the formula (IV):



wherein Y represents a residue of a blocking compound which
35 residue is capable of dissociating from the blocked polyisocyanate when heat-treated, m represents an integer of 2 or more and A represents an m-valent radical, said

further additional material having been heat-treated.

29. A shaped polyester composite material as claimed in claim 28, wherein said blocked polyisocyanate compound is an addition product of a polyisocyanate compound with a blocking compound selected from the group consisting of phenol compounds, aliphatic tertiary alcohol compounds, aromatic secondary amine compounds, aromatic imide compounds, lactam compounds, oxime compounds and sodium hydrogen sulfite.

30. A polyester fiber composite material as claimed in claim 29, wherein said blocking compound is from the group consisting of phenol, thiophenol, cresol, resorcin, tert-butyl alcohol, tert-pentyl alcohol, diphenyl amine, xylydine, phthalic acid imide, caprolactam, valerolactam, acetoxime, methylethylketoneoxime, cyclohexane oxime and sodium hydrogen sulfite.

31. A shaped polyester composite material as claimed in claim 29, wherein said polyisocyanate compound is selected from the group consisting of tolylene diisocyanate, methaphenylene diisocyanate, diphenylene diisocyanate, hexamethylene diisocyanate, polymethylenepolyphenyleneisocyanate, triphenylmethane triisocyanate, and addition product of above-mentioned polyisocyanate compounds with polyol compounds having two or more activated hydrogen atoms, in the molar ratio of the isocyanate radicals to the hydroxyl radicals of 1:1.

32. A shaped polyester composite material as claimed in claim 28, wherein said further additional material is in an amount of 0.1 to 10% based on the weight of said shaped substrate.

33. A shaped polyester composite material as claimed in claim 28, wherein said surface coating layer contains, in addition to said surface activating material, said additional material and said further additional material, a still further additional material comprising at least one rubber latex, said still further additional material having been heat-treated.

34. A shaped polyester composite material as claimed in claim 33, wherein said still further additional material is in an amount of 0.1 to 10% based on the weight of said shaped substrate.

5 35. A shaped polyester composite material as claimed in claim 33, wherein said rubber latex is selected from the group consisting of natural rubber latexes, styrene-butadiene copolymer latexes, butadiene-vinyl pyridine copolymer latexes, vinyl pyridine-styrene-butadiene
10 terpolymer latexes, acrylonitrile rubber latexes, acrylonitril-butadiene copolymer latexes and chloroprene rubber latexes.

36. A process for producing a shaped polyester composite material having an activated surface thereof,
15 comprising the steps of:

preparing a shaped substrate which comprises a matrix-forming material consisting essentially of an aromatic linear polyester and fine solid particles each comprising mainly silicon dioxide and having an average
20 size of 5 to 100 millimicrons, said silicon dioxide fine solid particles being dispersed in at least a portion of the polyester matrix located in a surface portion of said shaped substrate and the amount of said fine particles being in the range of 0.3 to 15% based on the weight of
25 said polyester matrix in which said fine particles are dispersed;

coating said silicon dioxide fine particle-containing surface portion of said shaped substrate, wherein said silicon dioxide fine particles are located,
30 with a surface coating liquid containing a surface activating material consisting of at least one member selected from the group consisting of silane coupling compounds and organic titanium compounds,

drying the resultant layer of said surface
35 coating liquid formed on said shaped substrate, and;
heat-treating the resultant precursory composite material at a temperature of 50°C or more but at

least 10°C below the melting point of said polyester matrix.

37. A process as claimed in claim 36, wherein said surface coating liquid contains said surface activating material in a concentration of 0.5% by weight or more.

5 38. A process as claimed in claim 36, wherein in said surface coating liquid, said surface activating material is dissolved in a solvent comprising at least one member selected from the group consisting of water, methyl alcohol, ethyl alcohol, trichloroethane, toluene and n-hexane.

10 39. A process as claimed in claim 36, wherein said heat-treatment is carried out for 30 to 300 seconds.